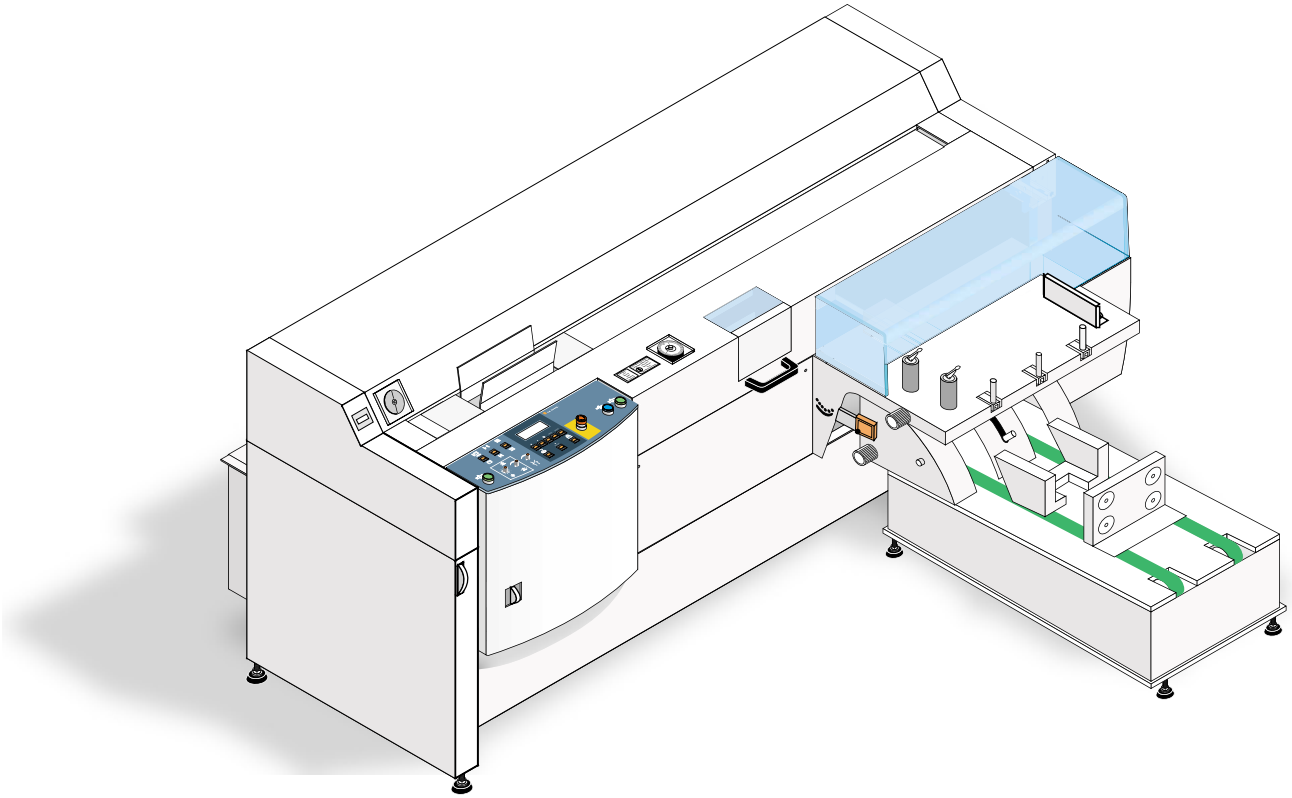
BOURG BINDER 3001



OPERATOR MANUAL

c.p. bourg s.a. n.v.
is
EURO-QUALITY SYSTEM
ISO 9001

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9.133.459

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1. INTRODUCTION

1.1 Foreword

Thank you for choosing a BOURG product.

The **BOURG BINDER 3001** is a perfect binder destined for the off line production of bound booklets.

This manual is a guide to operate the BOURG BINDER 3001.

Follow the instructions carefully and you should obtain years of excellent service from your Finishing on Demand system.

If you have any difficulty using your equipment, please call us and ask for technical assistance (phone numbers are listed on the last page). We will be delighted to help you.

1.2 Safety information

You are advised to read the "Instructions for a safe use" before you start to actually use the device.

Technical safety information such as safety data sheet can also be found.

Where applicable, cautions and warnings are used to draw your attention to safety precautions to be taken.

All information in this publication is based on the latest information available at the time of approval for printing.

We reserve the right to revise this publication and to make changes in the content without obligation to notify any person of such revisions or changes.

1.3 Safety labels

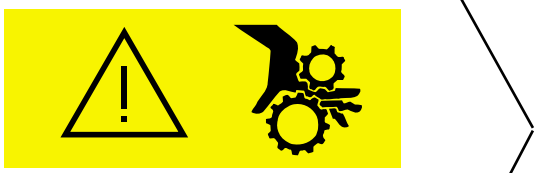
Please pay particular attention to the description of the following pictograms:

Caution: on a yellow background,
indicates a hazardous situation that can cause small or severe injury.

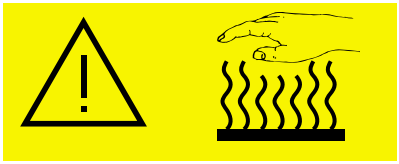
Warning: on a orange background is used to indicate a hazardous situation which has some probability of death or severe injury. Warning should not be considered for property damaged accidents unless personal injury risk is present.

Danger: on a red background:indicates a hazardous situation with a high risk of death or severe injury. The 'danger' sign does not apply to accidents causing material damage, unless they can cause personal injury.

An Emergency stop on the control panel can be pressed to disable the binder.

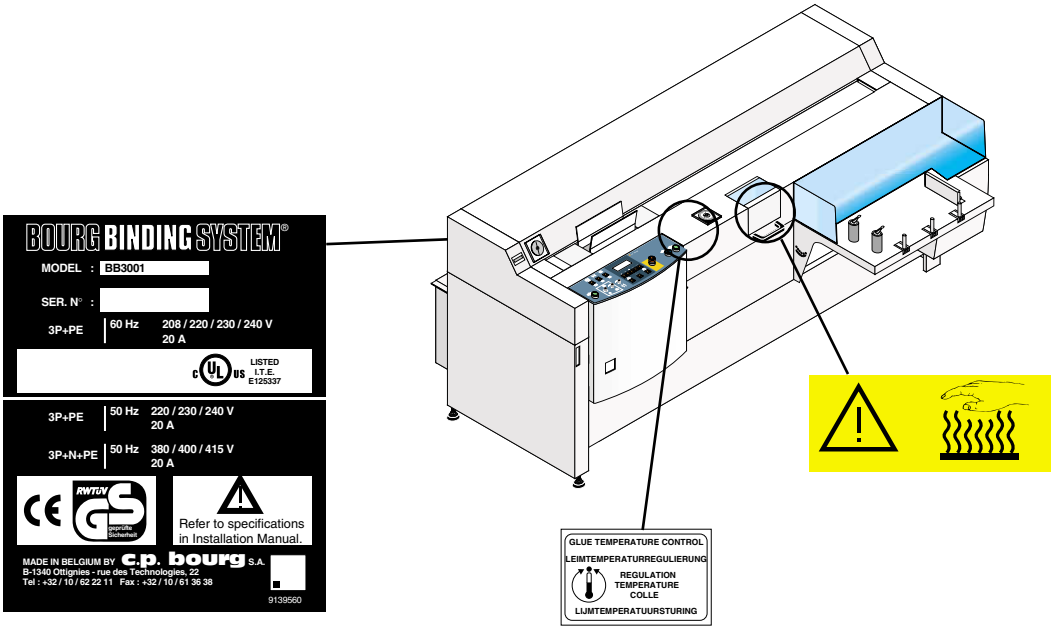


Dangerous area. Keep hands clear !

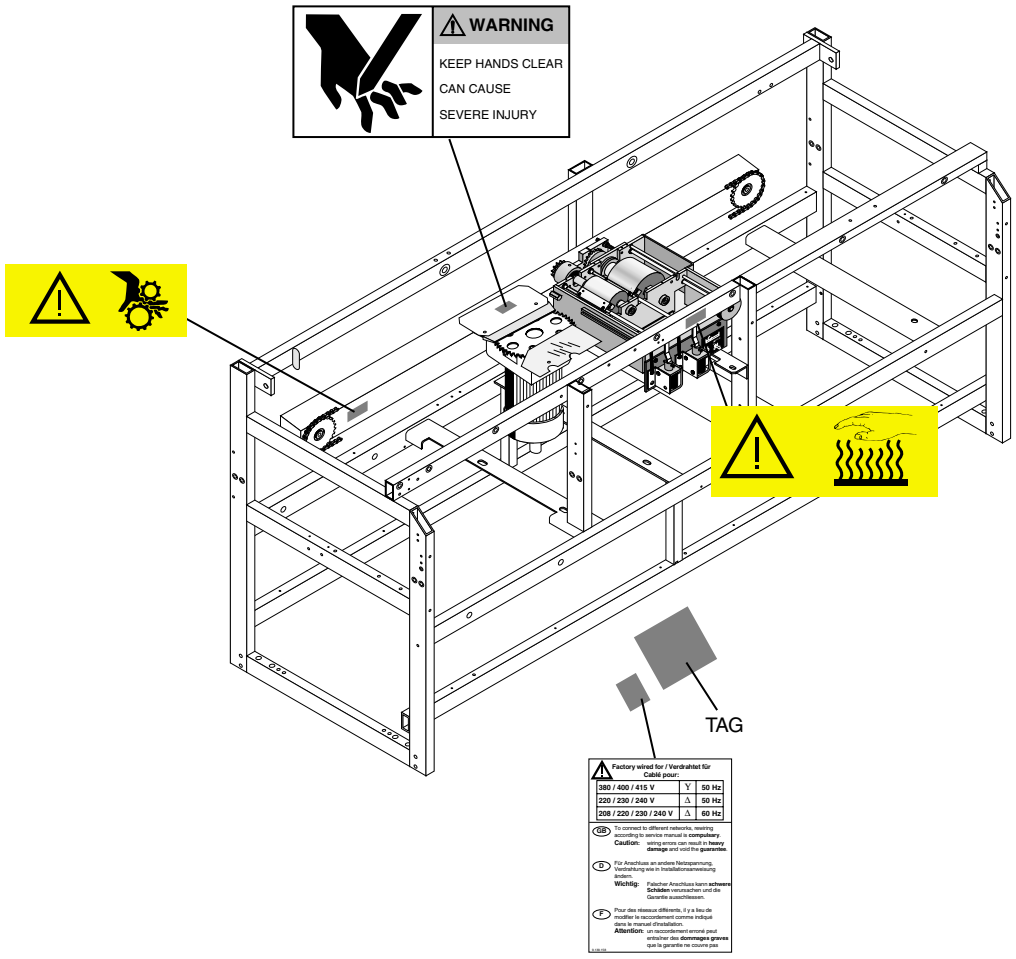


Hot glue. Burn hazard

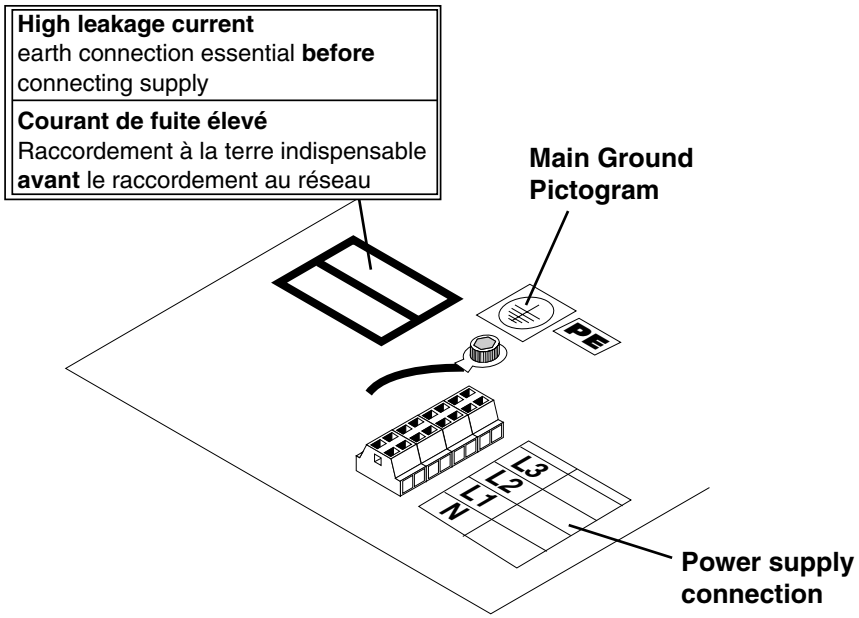
On the Top Cover


BOURG BINDING SYSTEM
MODEL : BB3001
SER. N° :
3P+PE | 60 Hz | 208 / 220 / 230 / 240 V 20 A
LISTED I.T.E. E125337
3P+PE | 50 Hz | 220 / 230 / 240 V 20 A
3P+N+PE | 50 Hz | 380 / 400 / 415 V 20 A
Refer to specifications in Installation Manual.
MADE IN BELGIUM BY c.p. bourg S.A.
B-1340 Ottignies - rue des Technologies, 22
Tel : +32 / 10 / 62 22 11 Fax : +32 / 10 / 61 36 38
9139560
GLUE TEMPERATURE CONTROL
LEIMTEMPERATURREGULIERUNG
REGULATION TEMPERATURE COLLE
LIJMTEMPERATUURSTURING

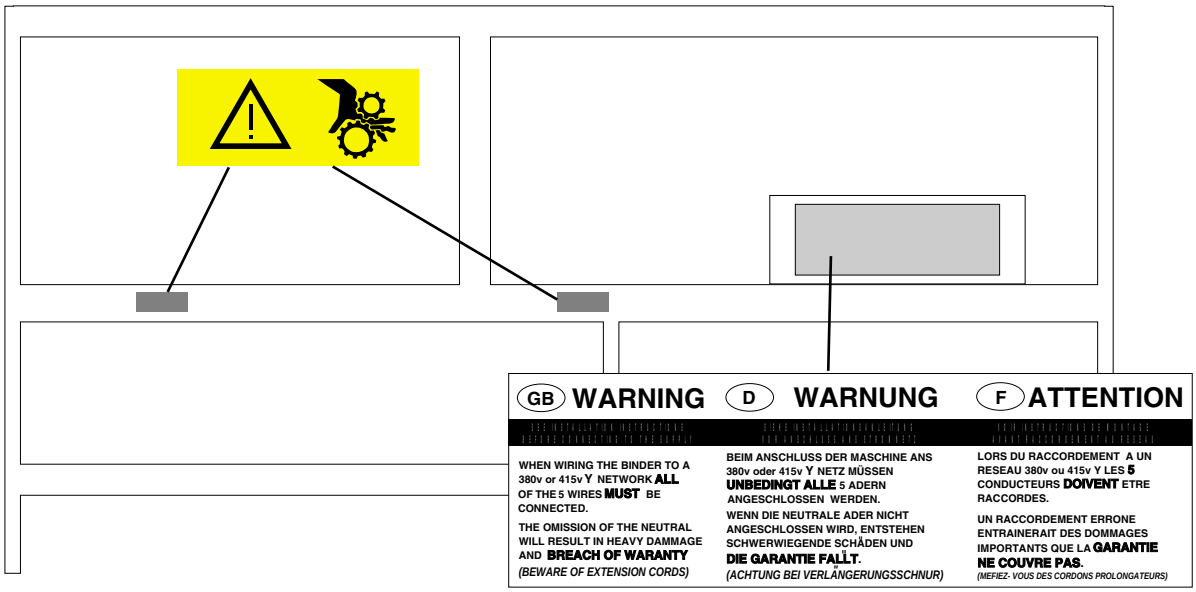
Inside the Binder


WARNING
KEEP HANDS CLEAR
CAN CAUSE
SEVERE INJURY
TAG
Factory wired for / Verdrahtet für
Cablé pour:
380 / 400 / 415 V | Y | 50 Hz
220 / 230 / 240 V | Δ | 50 Hz
208 / 220 / 230 / 240 V | Δ | 60 Hz
GB To connect to different networks, rewiring according to service manual is compulsory.
Caution: wiring errors can result in heavy damage and void the guarantee.
D Für Anschluss an andere Netzspannung, Verdrahtung wie in Installationsanweisung ändern.
Wichtig: Falscher Anschluss kann schwere Schäden verursachen und die Garantie ausschliessen.
F Pour des réseaux différents, il y a lieu de modifier le raccordement comme indiqué dans le manuel d'installation.
Attention: un raccordement erroné peut entraîner des dommages graves que la garantie ne couvre pas

In the Power Rack



On the back (inside)


GB WARNING
WHEN WIRING THE BINDER TO A 380v or 415v Y NETWORK ALL OF THE 5 WIRES MUST BE CONNECTED.
THE OMISSION OF THE NEUTRAL WILL RESULT IN HEAVY DAMMAGE AND BREACH OF WARANTY
(BEWARE OF EXTENSION CORDS)
D WARNUNG
BEIM ANSCHLUSS DER MASCHINE ANS 380v oder 415v Y NETZ MÜSSEN UNBEDINGT ALLE 5 ADERN ANGESCHLOSSEN WERDEN.
WENN DIE NEUTRALE ADER NICHT ANGESCHLOSSEN WIRD, ENTSTEHEN SCHWERWIEGENDE SCHÄDEN UND DIE GARANTIE FALLT.
(ACHTUNG BEI VERLÄNGERUNGSSCHNUR)
F ATTENTION
LORS DU RACCORDEMENT A UN RESEAU 380v ou 415v Y LES 5 CONDUCTEURS DOIVENT ETRE RACCORDES.
UN RACCORDEMENT ERRONE ENTRAINERAIT DES DOMMAGES IMPORTANTS QUE LA GARANTIE NE COUVRE PAS.
(MEFIEZ- VOUS DES CORDONS PROLONGATEURS)

1.4 Instructions for safe use

Bourg products have been tested in accordance with the strictest international safety standards. To help assure safety it is important that you observe the following rules:

Connection:

- Do not move the machine yourself, but contact our Customer Service.
- For equipment connected via a fixed connection to the network. The cable connection to the interface box should be easily accessible.
- Do not place the machine in rooms which are too small and insufficiently ventilated. **See safety data sheet (in appendix)** for information about space and ventilation requirements.

Note : • If an other type of glue is used of the recommended one (National Coolbind 1300), please refer to the safety data sheet of the used glue.
• Vapours which may be formed at elevated temperature may be irritating to eyes and respiratory tract. A local exhaust over glue tank and a good ventilation of the room are required.
• Different fume regeneration/extraction are available following the type of binder (see spare parts catalog).

Surroundings:

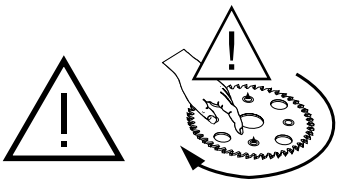
- Do not block the ventilation openings of the machine.
- Ensure that the machine is placed on a level, horizontal surface of sufficient strenght. See machine specifications for information about the weight of the equipment.

Maintenance:

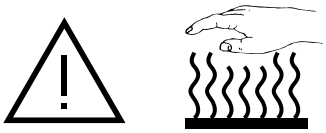
- Do not remove any screws from fixed panels.
- Do not carry out maintenance activities except for the parts and maintenance materials mentioned in this manual.
- Do not place any liquids on the machine.
- To avoid the risk of introducing hazards, all modifications to Bourg equipment are strictly reserved to properly qualified and trained service technicians.

General:

- Always use materials recommended by Bourg and developed for the Binder. Materials not approved by Bourg may result in machine failures.
- Do not use the machine when it is emitting unusual sounds. Remove the plug from the power socket or switch off the fixed connection to the network, and contact your Service provider.



Dangerous area
keep hands clear



Hot glue
burn hazard

Note: These safety alert symbols are for your personal safety. Never operate without all safety covers in place.

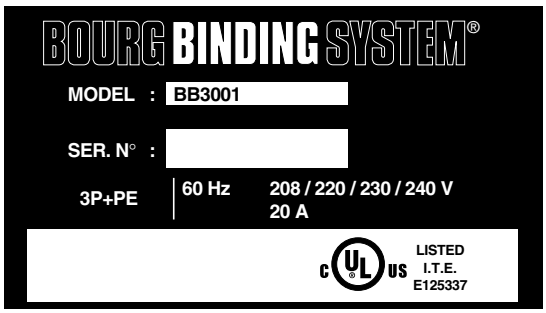
WARNING: This equipment has been tested and found to comply with the limits for a Class A digital device, pursuant to part 15 of the FCC* Rules. These limits are designed to provide reasonable protection against harmful interference when the equipment is operated in a commercial environment. This equipment generates, uses, and can radiate frequency energy and, if not installed and used in accordance with the instruction manual, may cause harmful interference to radio communications. Operation of this equipment in a residential area is likely to cause harmful interference in which case the user will be required to correct the interference at his own expense.

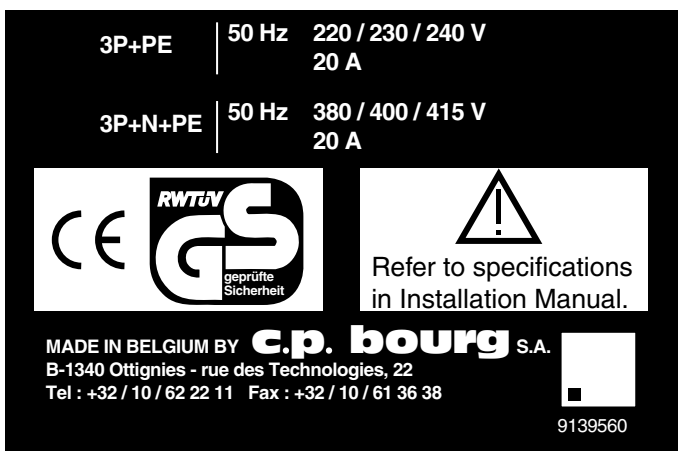
*F.C.C. = Federal Communications Commission.

Canadian Department of Communications Compliance Statement:
This equipment does not exceed Class A limits per radio noise emissions for digital apparatus set out in the Radio Interference Regulation of the Canadian Departement Communications.

1.5 Safety data sheet

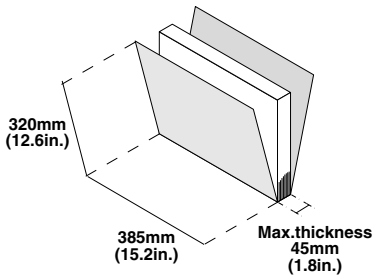
Model	BB 3001		
Description	Glue binder		
Max. process speed	Maximum 500 cycles/hour		
Dimensions & Weight	Lenght: 1,88 m	6.17 ft	
	Width: 1,16 m (3.8 ft) (with the possibility to split machine to have 695 mm (2.28 ft) width for narrow way)		
	Height: 1,06 m	3.48 ft	
	Weight: 400kg	882 lbs	
Voltage	208V/220V/230V/240V/3⏚	220V/230V/240V/3⏚	380V/400V/415V/3⏚N
Frequency	60 Hz	50 Hz	50 Hz
Current, rated	20 A	20 A	20 A
Power consumption, stand by	1500 W		
Power consumption, operation	3000 W		
Power consumption, maximum	5500 W		
Mains connection	Cable with fixed connection and separation switch		
Safety class	I	(IEC 536) Protective earth connection	
Protection class	IP 20	(IEC 529)	
Sound pressure level	Standby	In operation	
Operator position	55 db(A)	76 db(A)	
Radio interference	Complies with Directive 89/336/EEC		
Radiation	Not applicable		
Radiant heat	10224 Btu/hour		
Ozone emission	Not applicable		
Room volume	Recommendation: 95 m^3 (7 x 4,5 x 3 m) 3336 ft^3 (23x14.8x9.8 ft)		
Room ventilation	Recommendation: min. 47,5 m^3/h (natural ventilation)		
	For heat evacuation at continuous binding extra ventilation may be necessary		
Dust concentration	0,04 mg/m^3 at continous operation		
	(TLV for nuisance dust = 10 mg/m^3)		
Additionnal safety information	To avoid higher sound pressure levels than given above, the machine should be installed in a room with at least minimum room volume (see above) and favourable acoustical properties.		




3P+PE
50 Hz
220 / 230 / 240 V
20 A
3P+N+PE
50 Hz
380 / 400 / 415 V
20 A
RWTÜV
geprüfte Sicherheit
Refer to specifications in Installation Manual.
MADE IN BELGIUM BY c.p. bourg S.A.
B-1340 Ottignies - rue des Technologies, 22
Tel : +32 / 10 / 62 22 11 Fax : +32 / 10 / 61 36 38
9139560

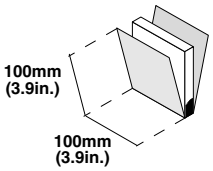
2.1 Specifications

MAX. BOOK DIMENSIONS

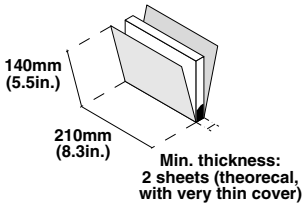


MIN. BOOK DIMENSIONS

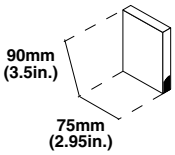
• With manual reception



• With automatic reception



• Padding mode
(without BBR - with manual reception and only by the low exit)



Book

Dimensions (max - min)	See the illustration above
Cover types	Glossy paper, with cutouts, with transparent front, “kromekote”, etc.
Cover weight	80-250 gsm (may require creasing) 30-90 lb cover
Paper weight	60-160 gsm 15-40 lb bond

Features

Cover pile height	60 mm 2.4 in.
Miss detector	Yes
Speed max.	up to 500 cycles/hour.
Glue temperature	From 140° C to 165° C (284°F to 392°F)
Milling + notching	Yes
Paper waste collection	Yes
Book counter	Yes
Start up timer	optional
Fume extractor with active charcoal filter	optional
Outdoor fume exhaust	optional

Machine

Dimensions: (l x w x h)	1,88 m x 1,16 m x 1,06 m (6.17 ft x 3.8 ft x 3.48ft)

Weight

Binder	400 kg	(882 lbs)
Output Unit (optional)	55 kg	(121 lbs)

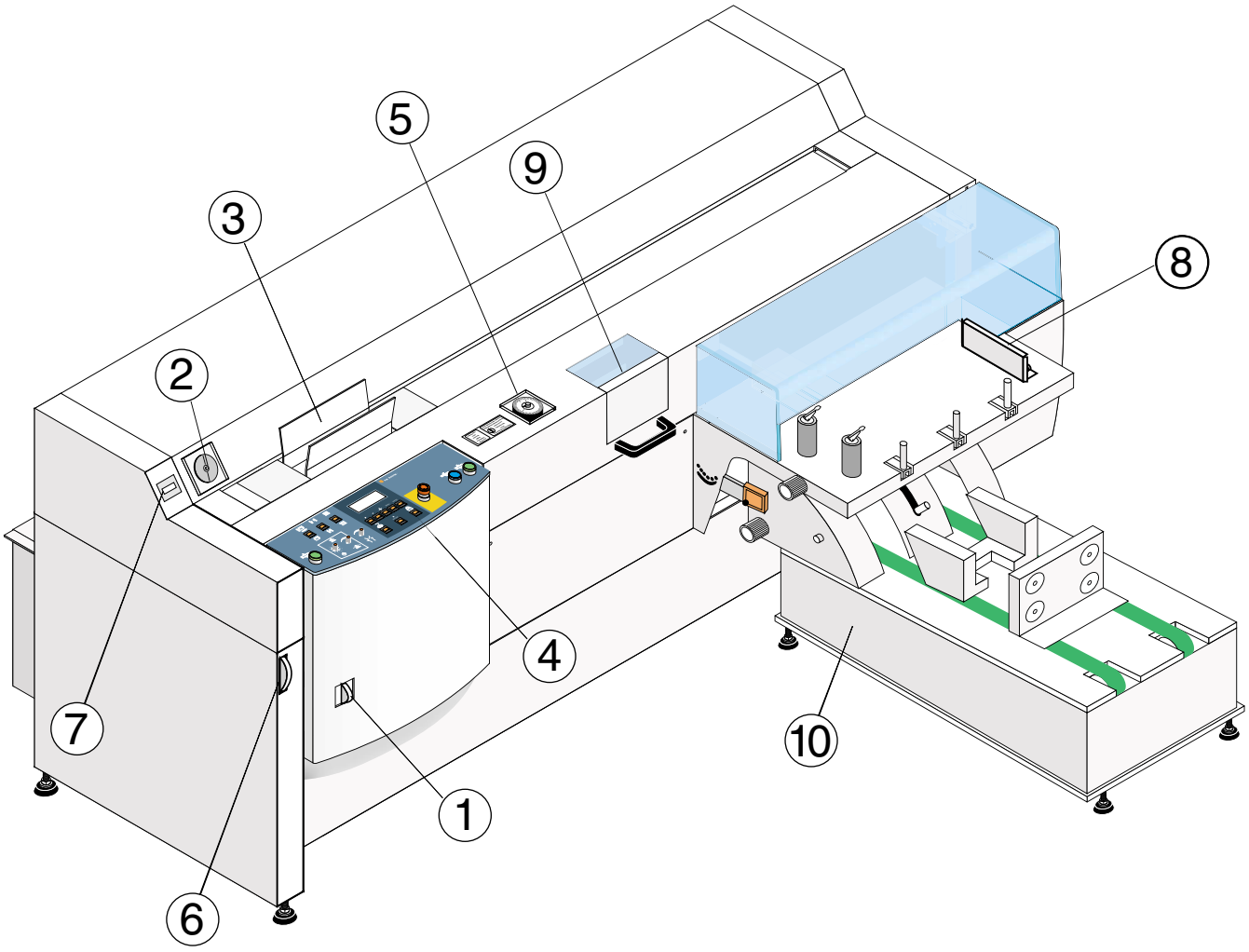
Electrical supply	208V/220V/230V/240V (60Hz)	Δ -20A
	220V/230V/240V (50Hz)	Δ -20A
	380V/400V/415V (50Hz)	Y -20A

Radiant heat	10224 Btu/hour
Noise level (Lpa)	76 dB (A) (at operator position)

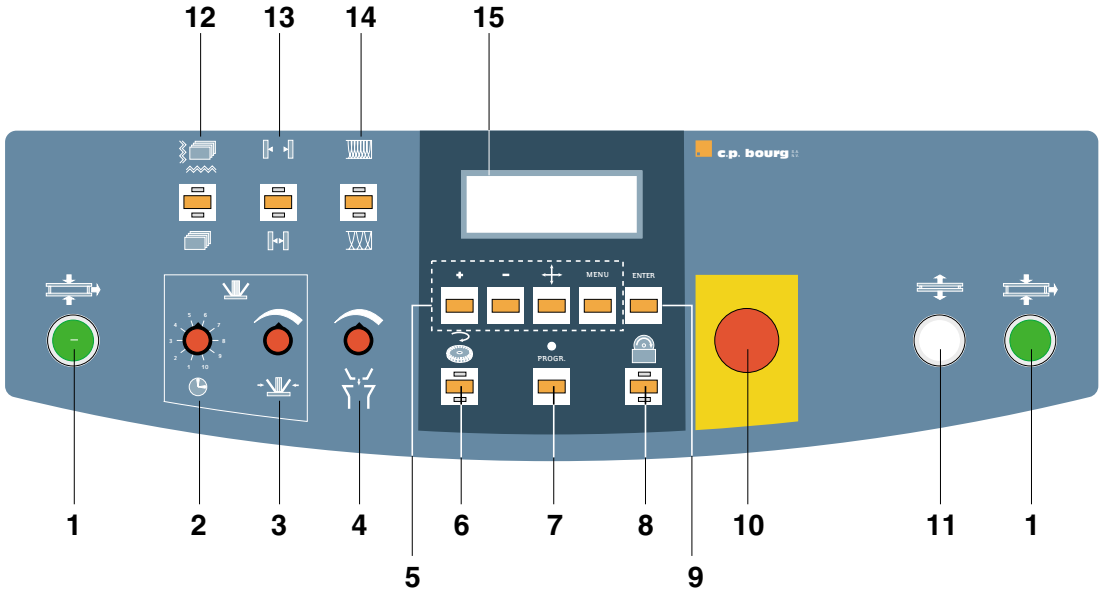
2.2 General

Binder description

1. Main Switch
2. Start up timer (optional)
   (to skip the 35 minutes warm up)
3. Handling loading area
4. Control panel
5. Thermostat
6. Depth milling adjustment
7. Depth milling indicator
8. Cover station
9. Glue tank access
10. Output unit (optional)



2.3 Control Panel



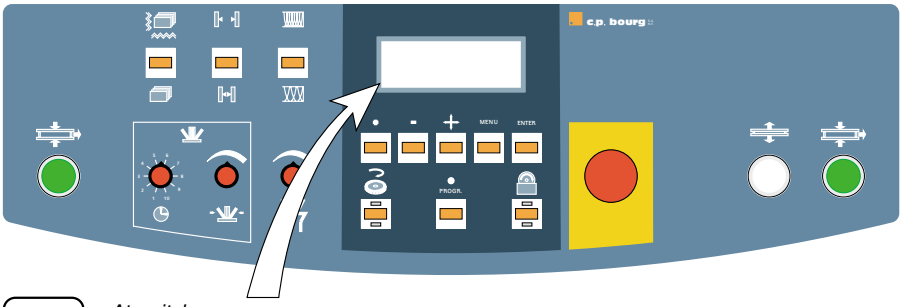
1. Closes the carriage and starts the Binding Process (press the two start buttons simultaneously)
2. Adjusts the clamping duration
3. Adjusts the lateral clamping pressure
4. Adjusts the suction level
5. Allows you to select menus and perform operation from these menus
6. Toggles the blade rotation ON/OFF
7. Selects the programs*
8. Toggles the glue tank heating (the drum rotation starts when the glue is warm enough)
9. Confirms the selection
10. Stop all operations in an emergency
11. Opens the carriage
12. Toggles jogger ON/OFF
13. Carriage normal or large pre-opening
14. Fixed speed ON/OFF
15. Liquid Crystal Display for menus and messages

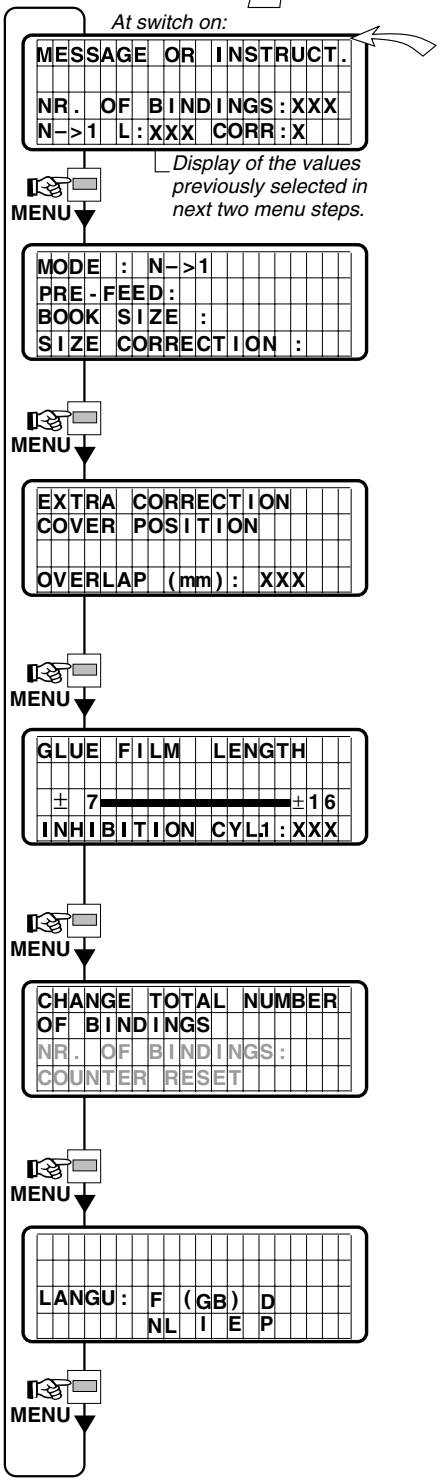
* *With cover*
or Without cover evacuation:top (for padding)
or Without cover evacuation:bottom (for padding)

Stop the drum rotation to select the program.
Confirm the choice by starting the drum rotation.

Note: In N→1 mode with pre-feed : yes. If the message "Cover sheet misfeed" is displayed, it is not possible to change the program.
You have to press on the emergency button and then change the program.

2.4 Control panel menus and messages





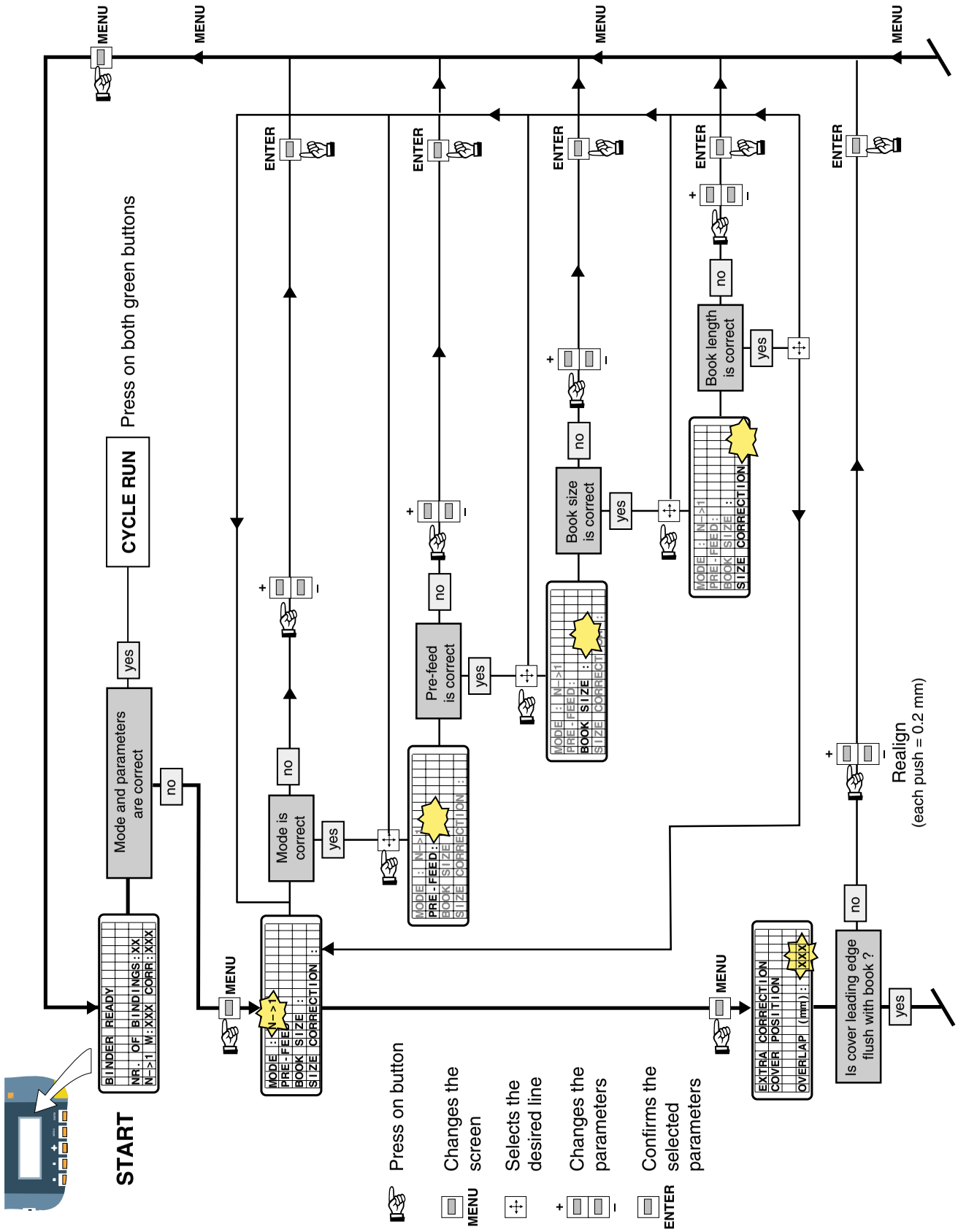
List of messages and instructions:

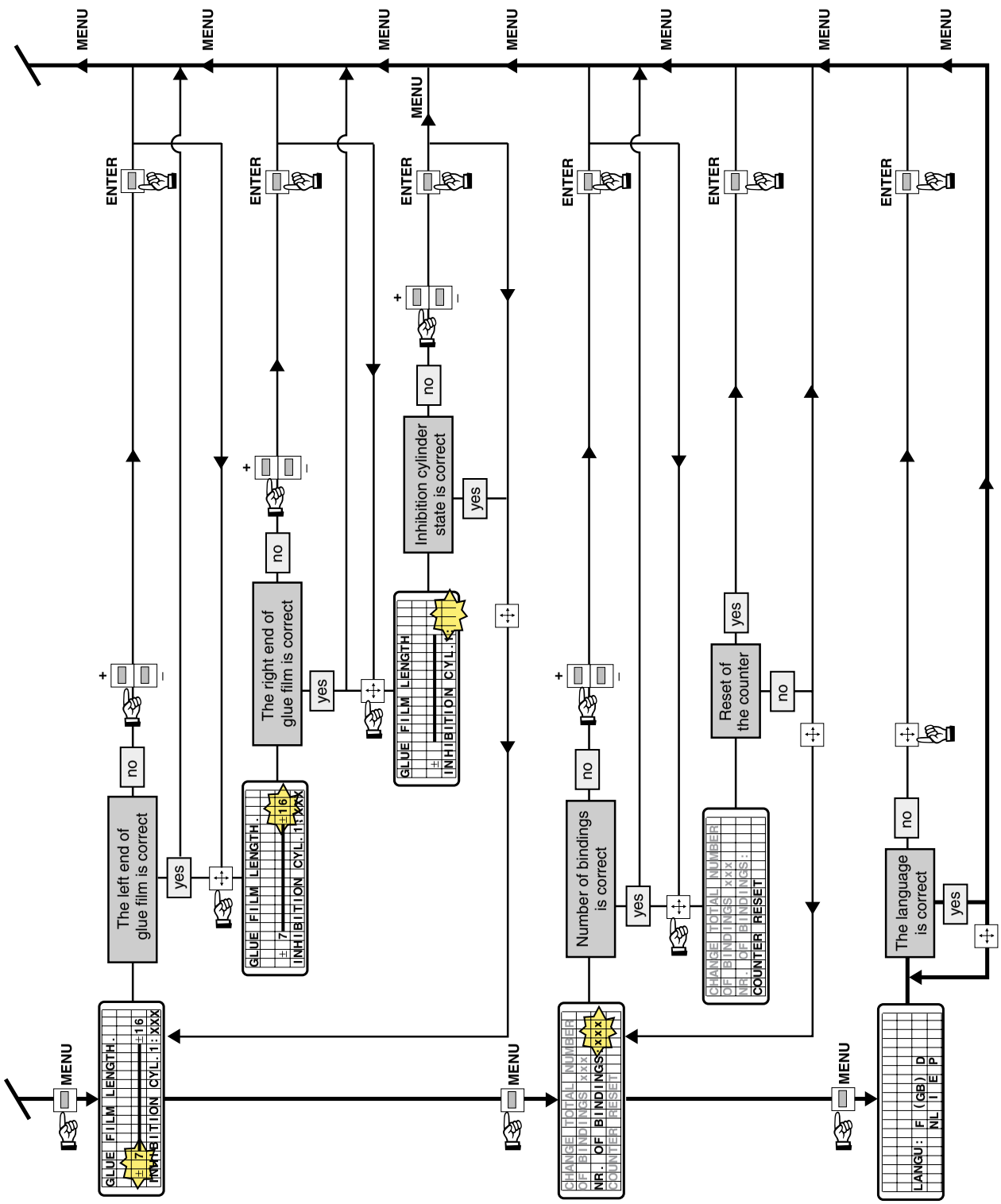
- Emergency pressed or hood not closed
- Reset
- Drum is heating but is still too cold.
- Problem with book in delivery area
- Lift perpex guard remove cover if any
- Press key drum to start heating
- Remove paper from binder if any
- Cover feeder did not move
- Binder is in test mode
- Spine is drying
- Depress both green push buttons
- Cover sheet misfeed
- Milling motor is overheated
- Switch off and open hood
- Binding in progress
- Problems with carriage position
- Remove cover sheet
- Heating is disabled. Push key to restore
- Delivery conveyer Not ready / connected
- Replace MCU battery
- Glue temperature too high
- Replace dust bag
- Binder is ready
- Open carriage and remove book

messages # on (earlier) eprom

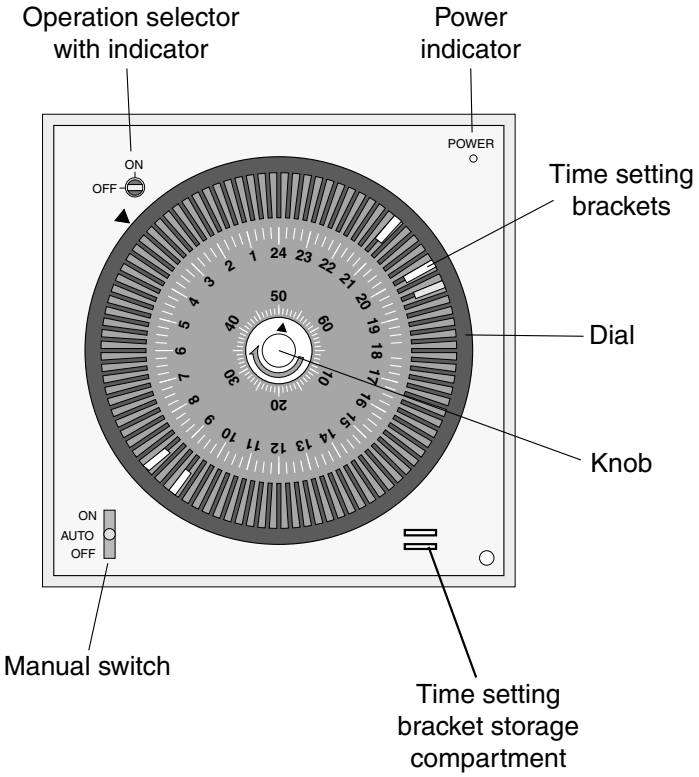
#	ERROR MESSAGES
1	Carriage open/close Motor problem M7 F35
2	Shutter motor Problem M15 F5
4	Cover nipping motor Problem - M14 (F12)
8	Suction bar problem Up/down motor M13 (F4)
9	Clutch or brake problem K12 (F2)
10	T21 Time out/process longer than one min
17	Notching tools index probl.
18	Error check S45 S49 and Tacho
19	Book too thick or carr switch probl

2.5 Change of binding parameters




MENU
ENTER
GLUE FILM LENGTH.
±7 ±16
INHIBITION CYL. 1: XXX
The left end of glue film is correct
yes
no
The right end of glue film is correct
Inhibition cylinder state is correct
CHANGE TOTAL NUMBER OF BINDINGS: xxx
NR. OF BINDINGS: xxxx
Number of bindings is correct
COUNTER RESET
Reset of the counter
LANGU: F (GB) D NL I E P
The language is correct

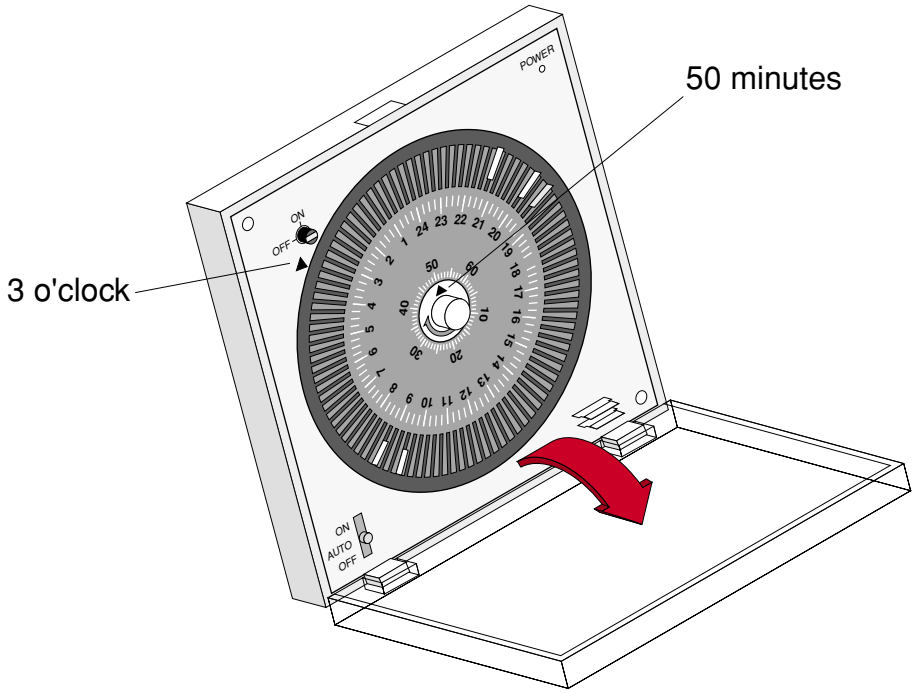
2.6 Instructions for timer use (optional)



Name	Function
Operation selector with indicator	Indicates the ON/OFF status of the control output; rotating the knob clockwise turns the control ouput ON/OFF.
Time setting brackets	Two time setting brackets are provided: ON time setting bracket and OFF time setting bracket. They turn the control output ON or OFF at the specified time.
Knob	Manually rotates the dial and indicates the present time in 1-minute units.
Dial	Holds time setting brackets and indicates the time in every 15 minutes.
Time setting bracket storage compartment	Stores the time setting bracket not in use.
Manual switch	AUTO: Produces the control output as specified by the time setting bracket position on the dial. ON: Normally turns ON the output irrespective of the time setting bracket position on the dial. OFF: Normally turns OFF the output irrespective of the time setting bracket position on the dial.
Power indicator	Lights when power is applied and indicates that the timer is in operation.

Settings

1. Remove the transparent cover from the front panel.



2. Rotate the center knob in the arrow direction (i.e., clockwise) to set the time. The present time can be set in 1-minute units. For example 3:50 as shown in the figure. Do not rotate the knob counterclockwise.

3. Two time setting brackets are provided: ON (gold) and OFF (silver). Be sure to use the correct bracket and securely insert it in the groove of the dial.

4. Alternately set the ON and OFF time setting brackets.

5. After setting the time, reattach the transparent cover to the front panel.

Operation

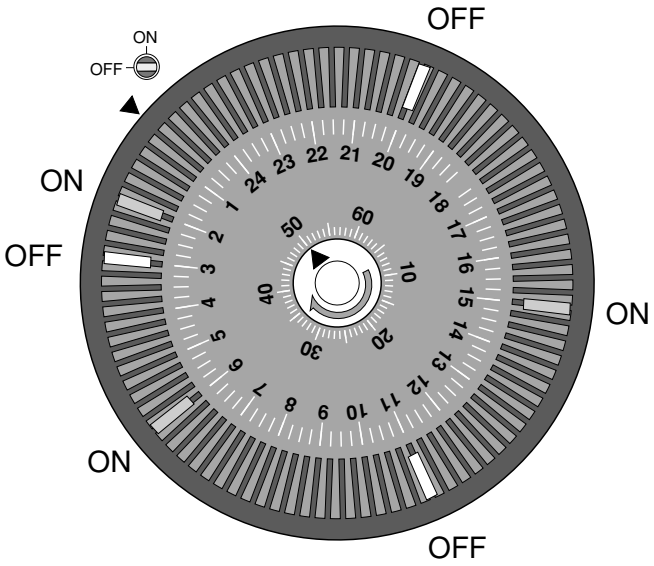
6. Firmly insert the ON/OFF time setting bracket to the desired time setting groove. However, do not insert it in a groove within ± 15 minutes distance from the dial groove that indicates the present time.

7. After the time setting bracket is fixed and with the power and load connected to the timer, rotate the knob in the arrow direction. Turn the dial one complete rotation to check if the control output is turned ON/OFF in accordance wit the setting of the time setting bracket on the dial.

8. Rotate the knob in the arrow direction and set the desired time according to step 2.

9. Now start the operation of the timer.

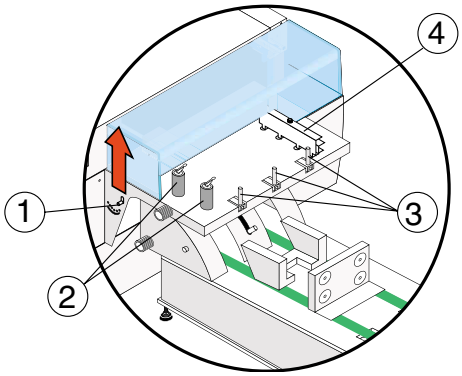
Example:



With the above setting the timing chart will be as follows:

2.7 Cover station

Loading of the cover station



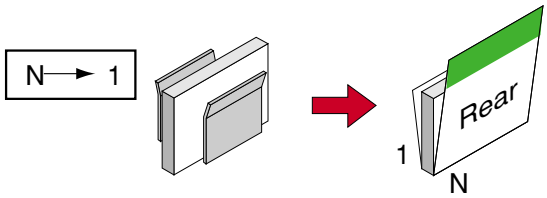
- Release the cover separators support bar (1).
- Move the magnetic side guides (2).
- Move the rear guide (3) if the format changes (the rear guides are locked with knurled knob located under the cover station).
- Load covers against the front guides and the right guide (4).

Note:- Visible part face down.
- Front page towards front guides (in Mode N→ 1, by default).

- Adjust rear guides (3) and side guides (2), against the pile of covers.

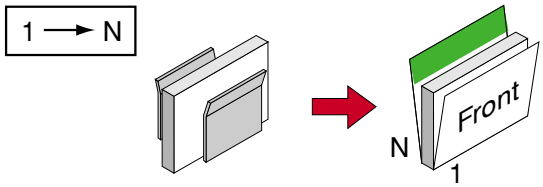
Three possibilities are selectable in menu # 2

Mode by default:

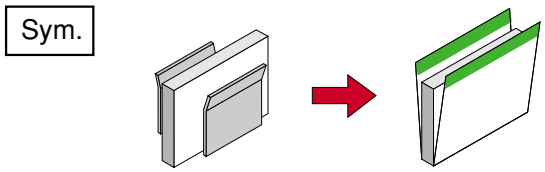


The cover are always loaded at the same place, whatever the thickness book is.
Use this mode for an optimal production.

Mode for special applications:



Mode for symmetrical cover:



Use this mode for booklet with notes on the spine of the cover.

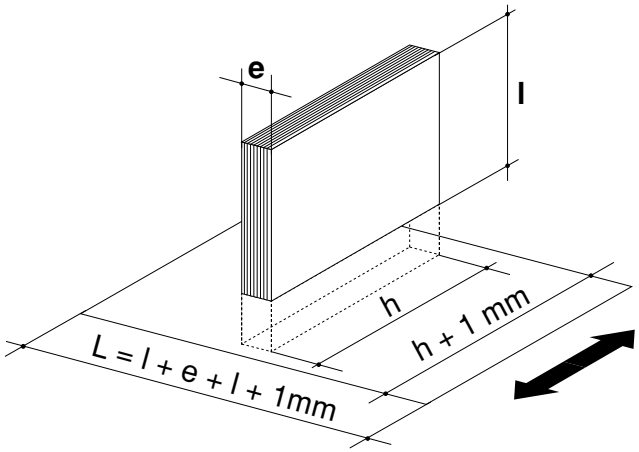
Cover dimensions :

Trimming of the book is mandatory for larger dimensions.

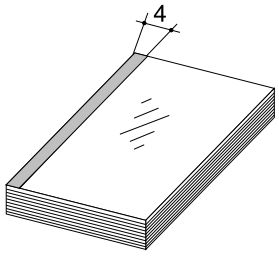
The grain of the covers should be parallel with the arrow for sharp folds around the spine.

Creasing of the cover may be necessary if the covers are cross-grained or if stiff material is used for the cover.

It is not possible to press heavy covers on very thin books. Thin covers should not be pressed on thick books either.



The paper side of covers with transparent fronts and paper backs, must be wrapped around the spine at least 4 mm (.16 in.).

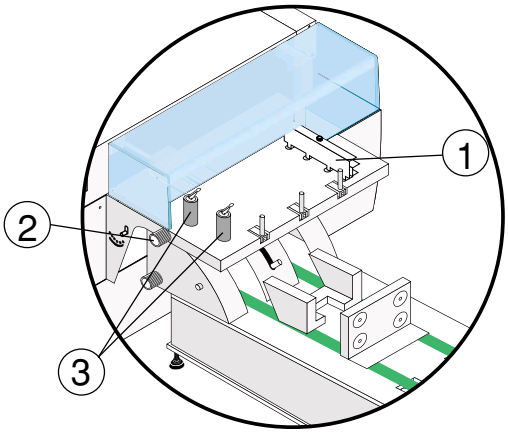


Settings

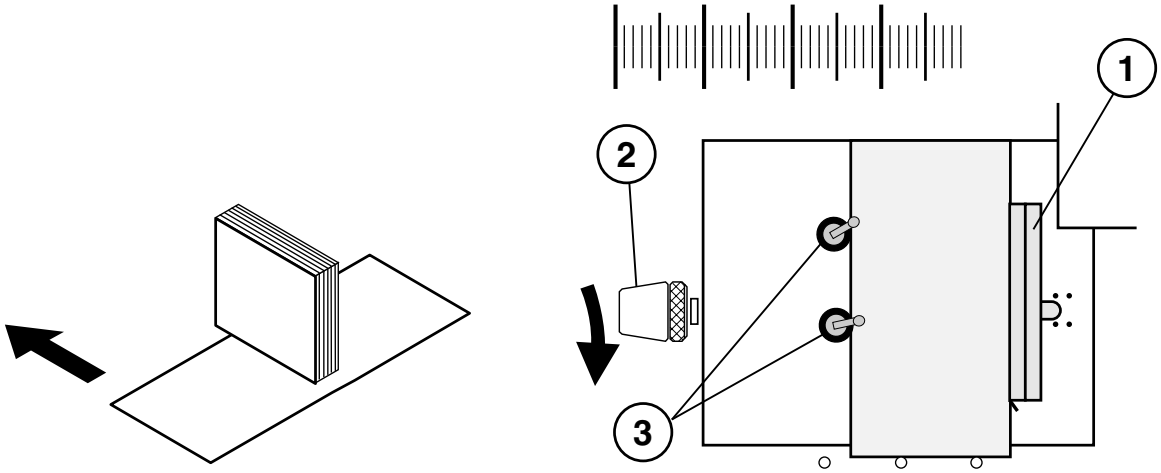
Positioning the cover on the book:

The machine has been factory set to place a perfectly squared cover, in line with the right edge of the booklet. The guide angular adjustment is “0”. And its RH ◄► LH adjustment is made to get the cover aligned with the right edge of the booklet. Do not change this except :

- if you use an unsquared cover.
- if you do not want to align the cover with the right edge of the booklet.

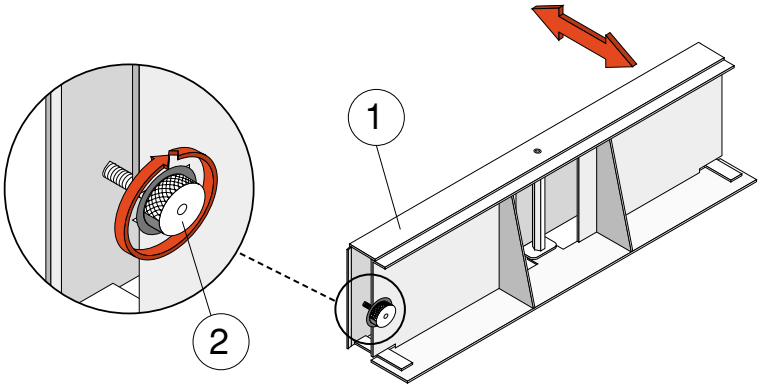


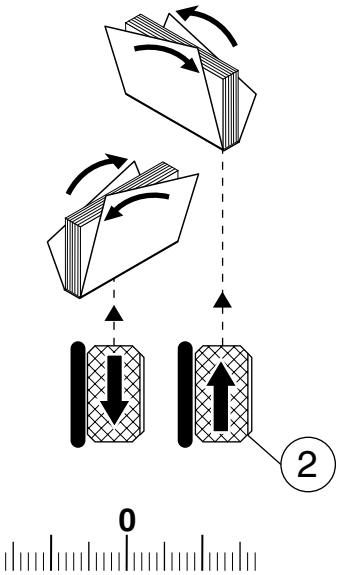
Lateral adjustment:



- Adjust the position of the right side guide (1) using the knob (2) to correctly align the cover to the book.
- Lock the magnetic side guides (3) on the left against the pile of covers.

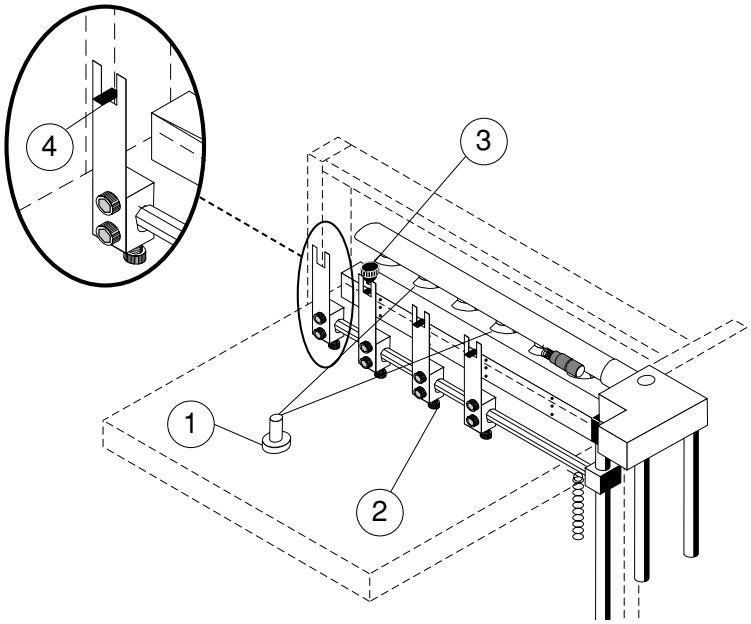
Squaring of the covers:

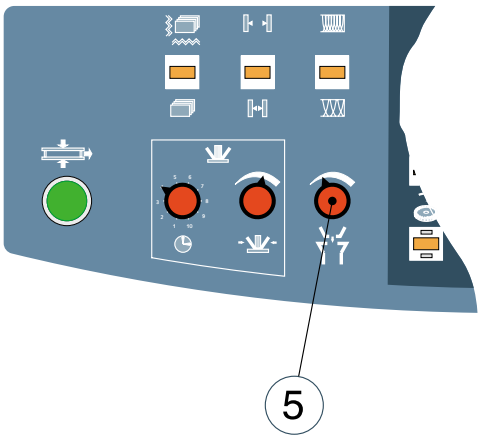




Compensation for covers not cut exactly square is provided for by moving right side guide (1) askew by means of knob (2).
Before adjusting (2), verify that the guide is unlocked to prevent bows or warps.
After the adjustment, lock the knob (2).

Cover picking and front cover separators:

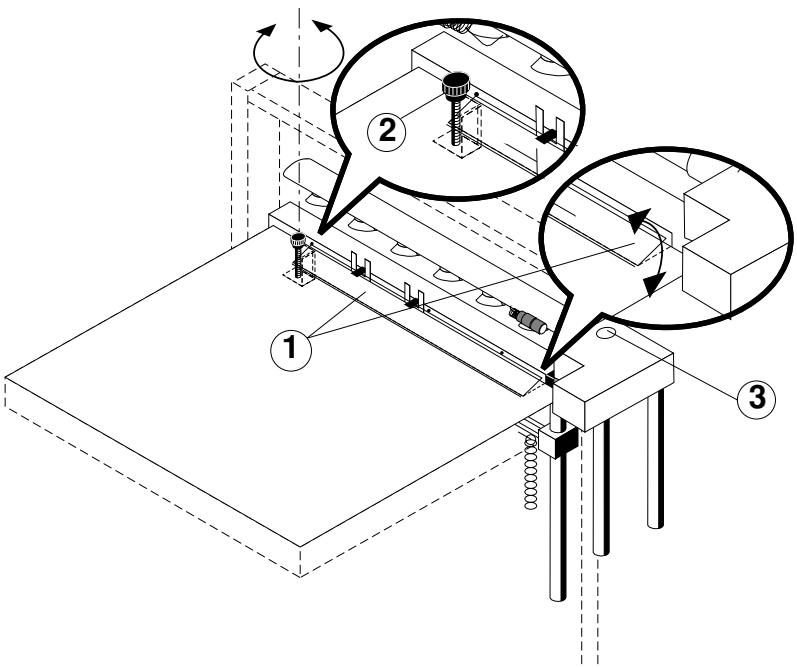




- If the suction cups on the left extend beyond the width of the cover, you must place the plastic studs (1) from the tool kit in the suction cups.
- According to cover material, one more plastic stud (1) may be required in the suction cup situed in the middle of the front edge as well.
- Vacuum is continuously adjustable by pot (5).
- Adjust the position and number of the front cover separators (4) only if necessary for optimum cover separation.
- Use knobs (2) to move the separators (4).
- Use the knob (3) to adjust the air flow.

- In some case, the leading edge (1) of the cover store can be lifted by adjusting knob (2).

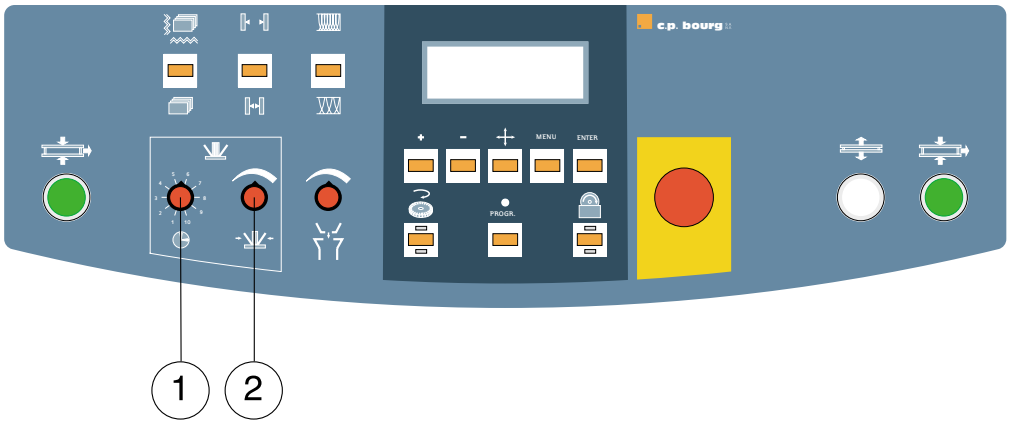
- Make sure to adjust the suction cup support bar accordingly by loosening the screw (3).
  This keeps the cover parallel with the tilted suction cups.



Cover clamping :

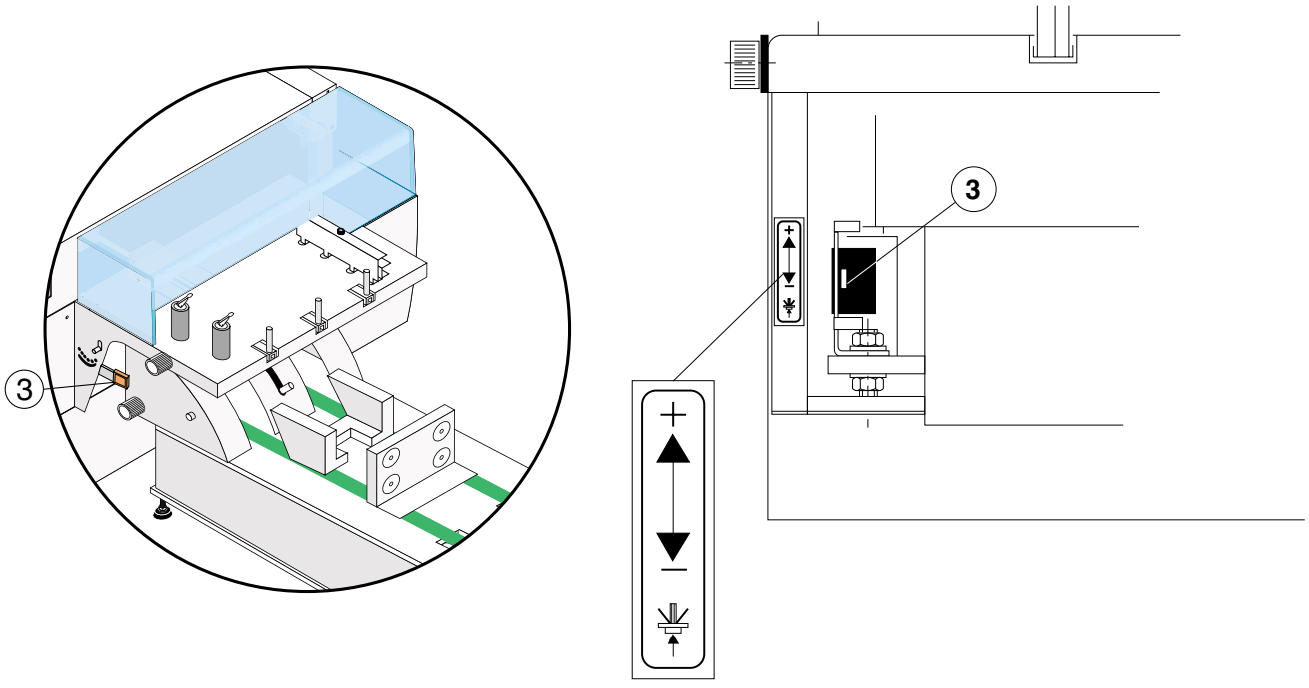
On control panel :

- Selector (1) provides choices for its duration.
- Potentiometer (2) adjusts lateral clamping pressure.



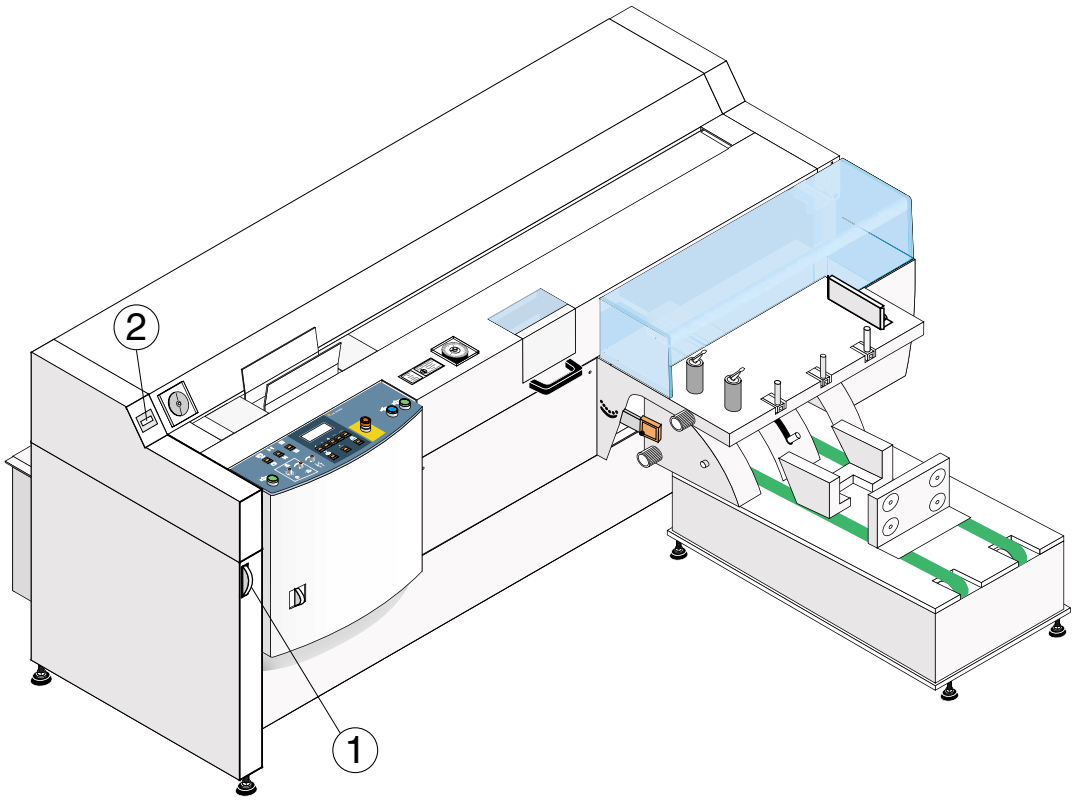
Under cover stockplate:

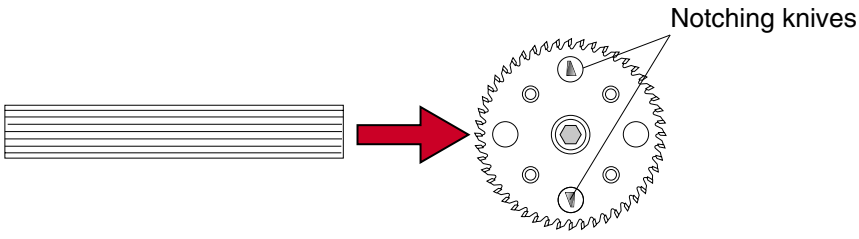
- The notched handle (3), located under the cover station, adjusts pressure on book spine.
- The six positions correspond to the various thicknesses of the covers.

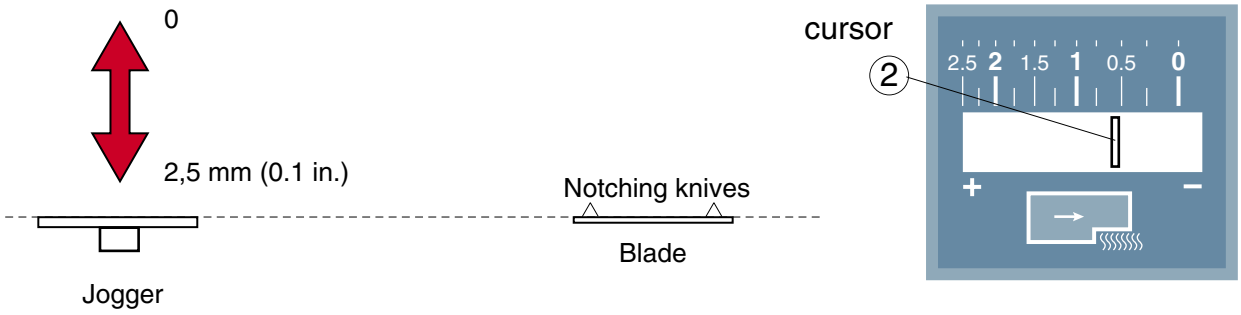


2.8 Milling depth adjustment

Turn knurling wheel (1) to adjust the jogger height.







The cursor (2) indicates the jogger level according to the milling blade.
The jogger height can be adjusted to remove until 2.5 mm (0.1 in.) of material from the spine of the book.
O means “no milling”.

2.5 mm (0.1 in.) means maximum milling
2.5 mm (0.1 in.) of material are removed from the spine of the book.

- Milling motor will automatically start if jogger is not in upper position. There is a time out on the milling motor rotation.
- When jogger is in upper position, the operator will have to make a choice:
    - If operator ask for the motor to run (notching without milling) the motor will immediately start and there will be no time out on the motor rotation (unless the operator ask for the motor to stop , activate the emergency knob or open any cover).
    - If the operator ask to not use the motor, the machine will check if the paper path is clear from scoring tools.
        - If paper path is clear from tools, the UI will indicate “binder ready”.
        - If the notching tools are in the paper path, the binder will ready after the indexation tools (a few seconds).

2.9 Glue

Glue drum temperature:

To select between 140° and 165°C using the knob (1)
For the supplied glue (National coolbind 1300) select 140°C.
See safety data sheet (in appendix) for information about space and ventilation requirements.

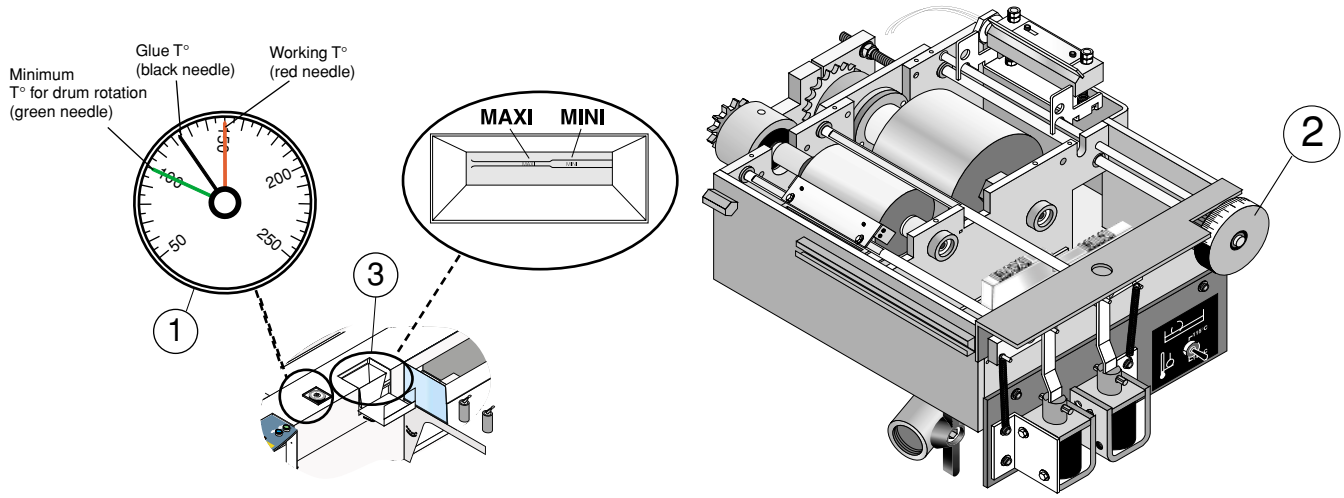
Note : • If an other type of glue is used of the recommended one (National Coolbind 1300), please refer to the safety data sheet of the used glue.
• Vapours which may be formed at elevated temperature may be irritating to eyes and respiratory tract. A local exhaust over glue tank and a good ventilation of the room are required.
• Different fume regeneration/extraction are available following the type of binder (see spare parts catalog).

Glue level in the tank:

The check of the glue level takes place when the drums are rotating. When the level gets low, the minimum mark in the bottom of the tank in the glue compartment becomes visible.* To avoid an overflow, fill the tank with glue granules until they reach to the bottom of the funnel (3). When melted, they should just cover the maximum mark.

CAUTION: The glue amount should never be over the maximum level either below the minimum level.
Prefer a regular filling.

* *Neglecting to refill in time may result in damage to the glue tank.*



Glue distribution :

- The film of glue on the drum is controlled automatically.
- A glue spreader removes the excess of glue from the spine of the book, its height is adjustable by means of a thumbwheel (2):
  - At zero, almost all the glue is removed from the spine.
  - At 9, about 1 mm of glue is left on the spine.

Important: Never change the adjustment (2) by more than two graduations without checking the result.
Never change the adjustment when glue is not at fusion temperature (glue drums rotating)

Over temperature safety detection:

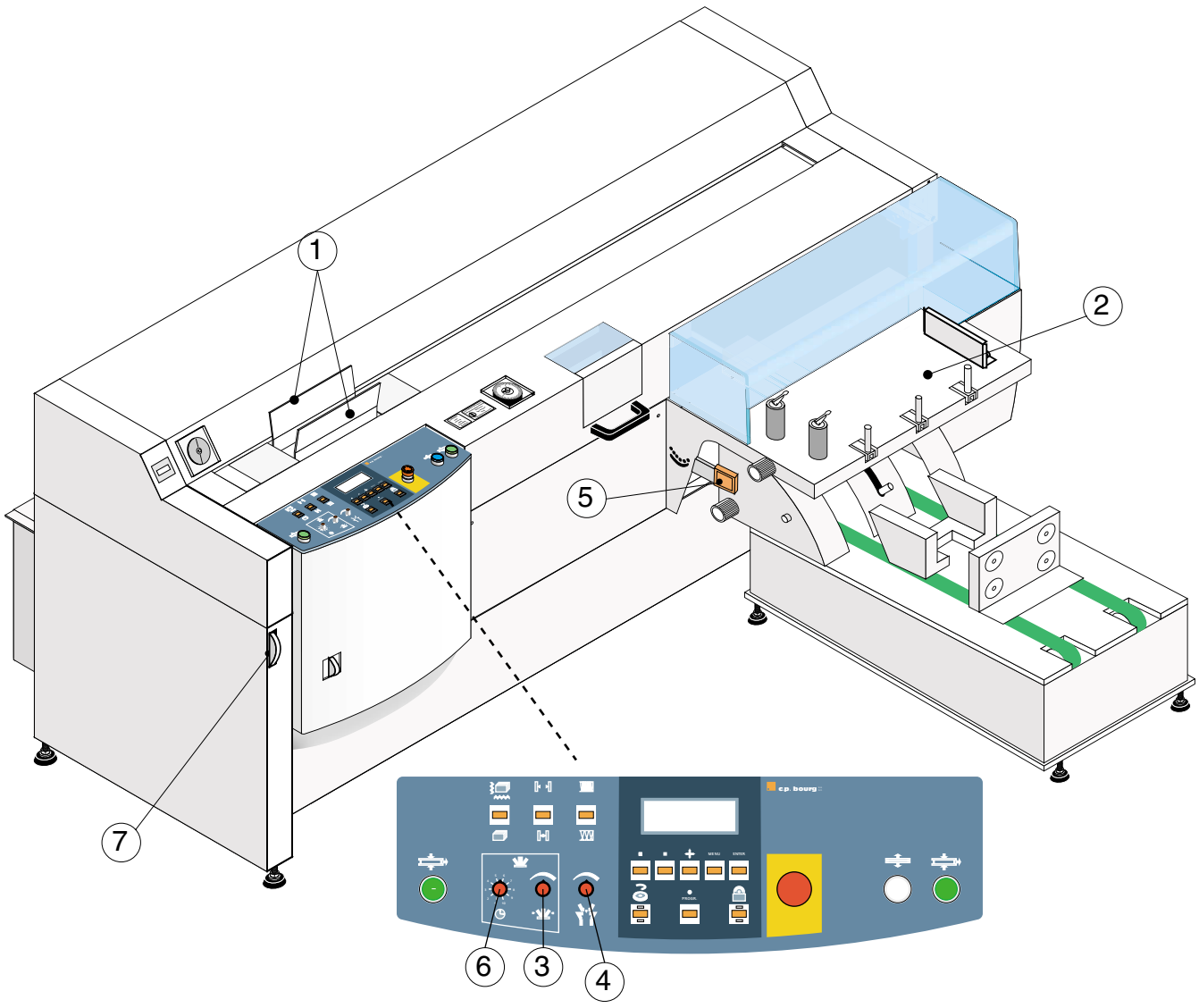
- To comply with international safety regulations, the glue tank and the drum are equipped of temperature regulation circuitry. The system stops the machine if the glue temperature exceeds 170°C either on one or on other sensors.
  This system requires a working temperature below 165°C and a glue flash point higher than 200°C.

- After the system activated, the machine shut down and the binder restart could only be done by a technician.

Note : • Please refer to the safety data sheet (in appendix) for the National Coolbind 1300.
• If an other type of glue is used of the recommended one (National Coolbind 1300), please refer to the safety data sheet of the used glue.
• Vapours which may be formed at elevated temperature may be irritating to eyes and respiratory tract. A local exhaust over glue tank and a good ventilation of the room are required.
• Different fume regeneration/extraction are available following the type of binder (see spare parts catalog).

2.10 To set up the Binder module

- Select and clip the proper pair of carriage jaws extensions (1) and install them in the corresponding holes in carriage jaws.
- Load the cover station (2)
- Select the proper size book in the second step of the menu
- Select side cover clamping pressure (3).
- Select suction level (4)
- Select spine pressure (5)
- Select the duration of the cover clamping (6)
- Adjust the jogger height (7)



2.11 Output unit (optional)

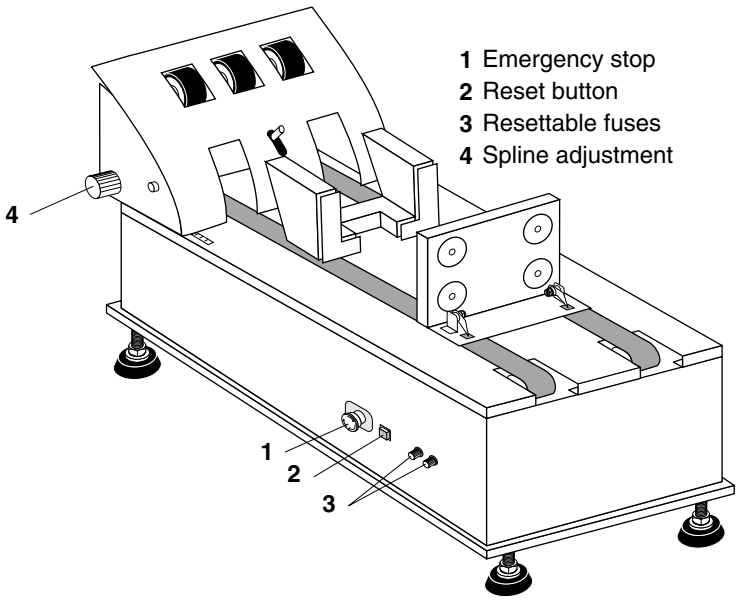
- When the booklets are delivered on the output unit, the glue is still soft and warm. Do no take them immediately.

- Adjust the receiver spline with the thickness book by using the knob (4) according to the size of the books, allow sufficient space.

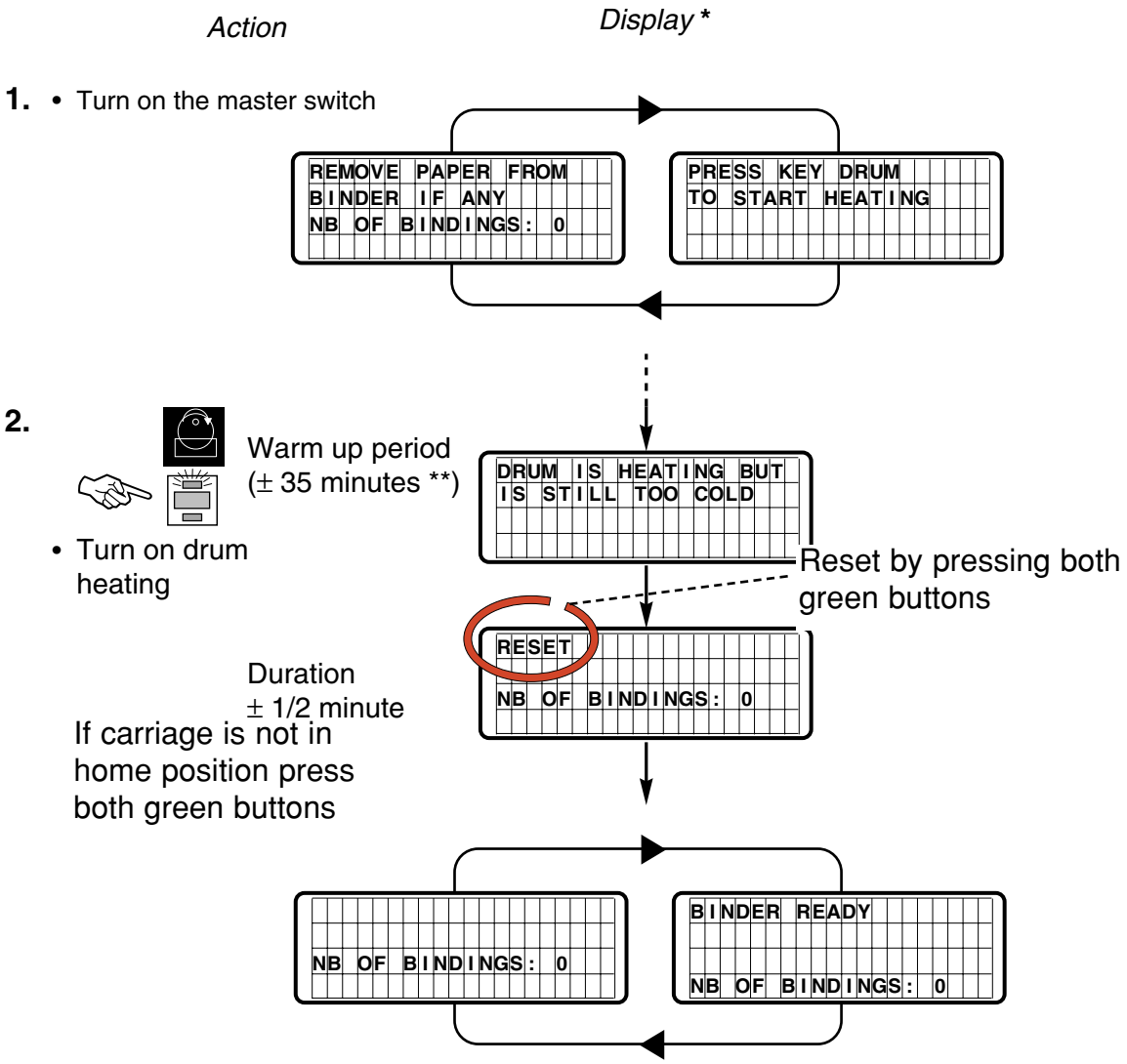
- For your convenience there is an emergency stop (1) which you can press with your feet.
  Further to the unlocking of the switch, a push on button (2) is required to reset the process.

- The fuses (3) are resettable after tripping.

- When the unit is full, the message “empty output unit” appears in the display. Empty the BBR and press on the button (2).



2.12 Binding condition



* *no message: the start up timer is not satisfied. (if running)*

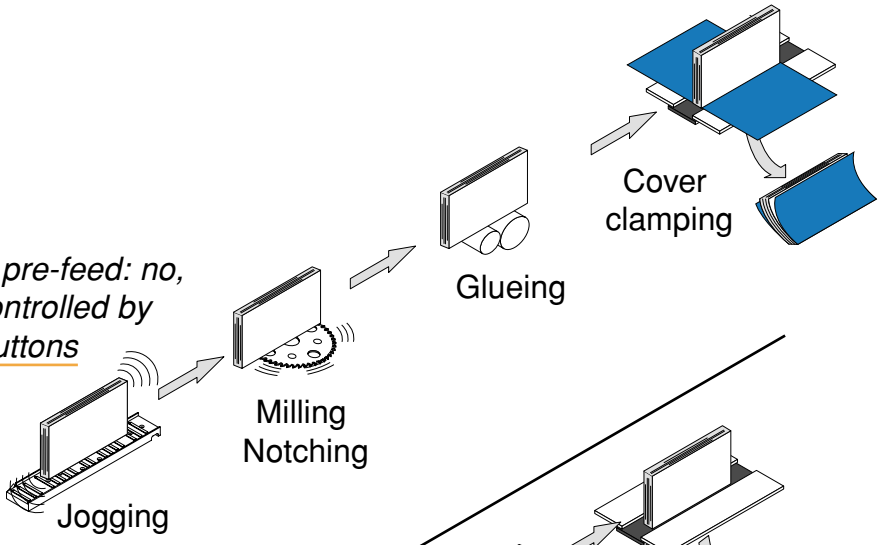
** *10 minutes only if tank is already warmed up by start up timer.*

2.13 Cycle description

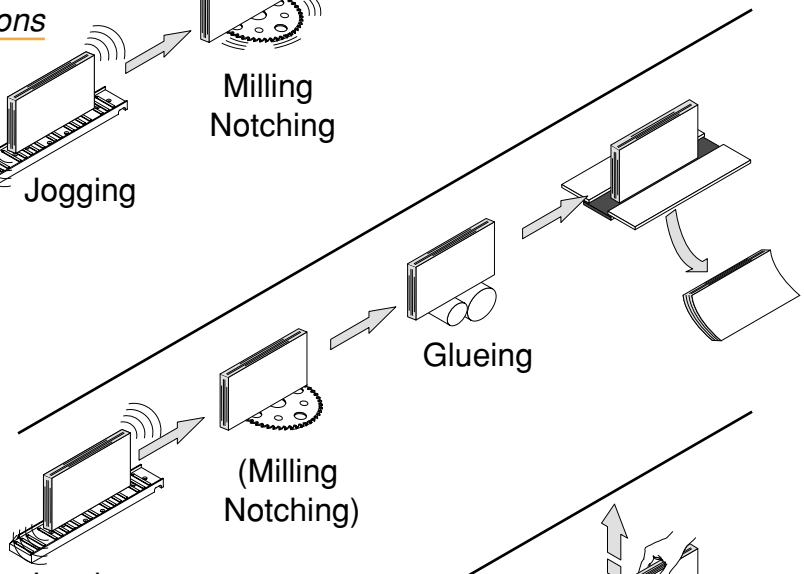
• Insert the set of sheets in the carriage.
• The jogging can be interrupted by the footswitch or switch ON/OFF (see “control panel”).
• Close the carriage by pressing both green buttons simultaneously.

Automatic process with cover

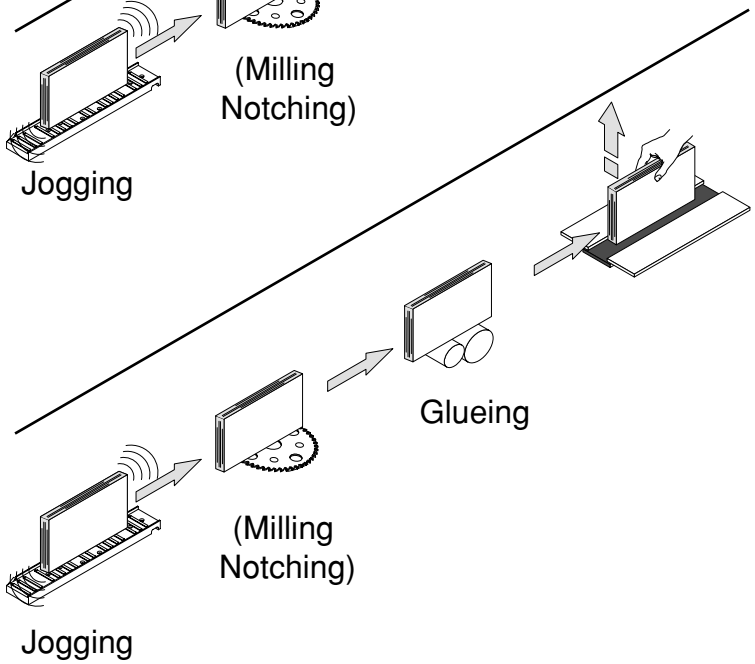
Note:
In mode N⟶1 with pre-feed: no, the cover feeding is controlled by pressing both green buttons



Automatic process without cover evacuation: bottom



Automatic process without cover evacuation: top



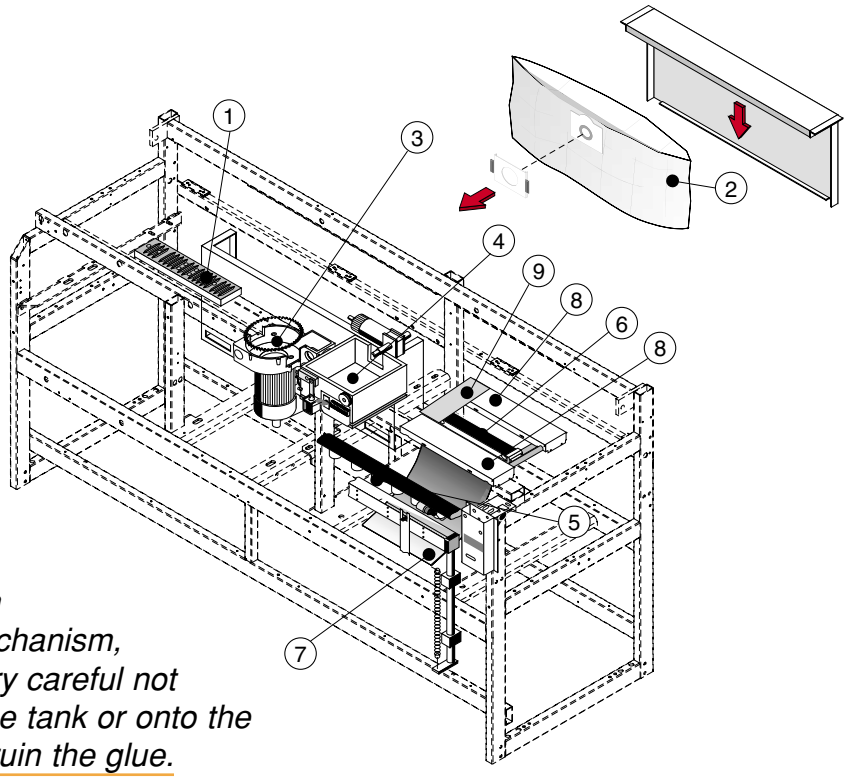
• Carriage goes back to loading area and stand-by.*

** The carriage opening is pre-adjusted to match the thickness of the previous book.*

3.1 Preventive maintenance

Due to the advanced nature of the materials used in the binder, the preventive maintenance is reduced to the level of inspection, cleaning and occasional adjustments.

Warning: Disconnect the main power before you perform the maintenance



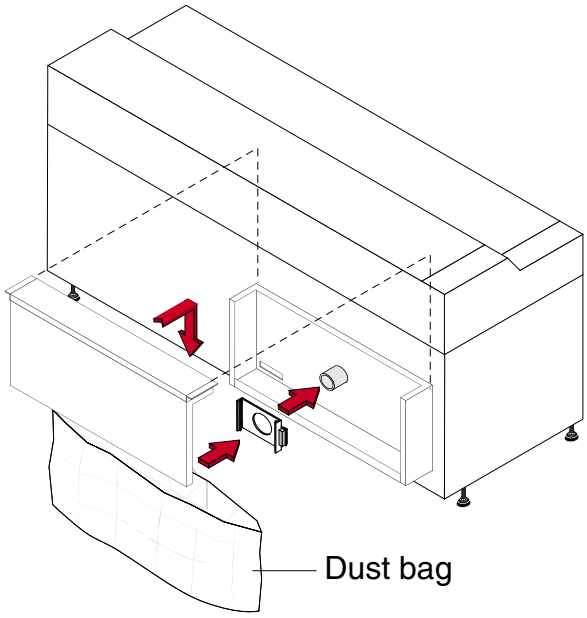
Check the ejection path and cover clamp for particles of glue. Clean as required, otherwise the clamps may freeze up and may blow a fuse.
Use a cloth with spirit (SOLVOID.RAP N° 9900 107).

Note: Silicone spray can be used to stop the glue from sticking to the mechanism, but if used, be very careful not to spray in the glue tank or onto the drum.This would ruin the glue.

Caution : The glue tank is hot. Use protection gloves to work around it

Ref	Description	Frequence		Cleaning	Replacement	Comment
		Daily	Weekly			
1	Vibrating table		X	X		
2	Dust bag	X				Each time you change the dust bag check for stuffing in the milling housing and for paper strips in the bag. If the number of paper strips is excessive, call for service
3	Milling housing	X		X		There should be no stuffing in the milling housing
4	Glue tank		X	X	Purge glue	Check the glue for quality and for oxidation. Refill by operator. Call ingeneer for replacement of glue
5	Suction cup		X	X		Replace as necessary
6	Cover nipping plate	X		X		Check state Teflon covering
7	Evacuation guide	X		X		Check from the top with clamping station fully open
8	Nippers	X		X		
9	Rear clamp guard nipping station	X		X		Remove glue strings

3.2 Paper dust bag replacement



- Replacement about every 20 hours of binding is important, otherwise paper dust could ruin the glue.
- Remove and throw away the bag.
- See the illustration above to hook a new one.
- A pressure switch detects the "*Replace dust bag"* situation.

Note : The message "Replace dust bag" is displayed on the control panel.
The machine will not start when this message appears.
Message and stop condition can be erased by depressing the 2 green knobs.

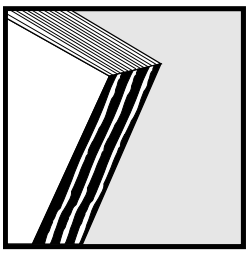
Glue smell suppression is provided (optional).

When smell neutralization decreases, it is time to replace the filters.
Call technician.

Symptom	Probable cause	Remedy
The cover is not square on the paper offset (skewed).	The cover is not cut square. The cover station and paper pile are not square to the machine.	Check the covers. Check the squareness with respect to the nippers.
The cover is too far on the right. The cover is too far on the left.		Adjust the cover station stop to the left. Adjust the cover station stop to the right.
There is not enough glue on the back of the book.	The glue spreader is too high.	Check the glue spreader.
The pages are warped where the glue is applied (spread out).	The paper is too weak for milling.	Check the cutter. Check the paper quality.
The covers suffer from nail head.	The cover nipping is too hard. The cover is too weak for the paper in the nippers.	Check the pressure. Check the cover material.
There is poor ejection and nipping.	There is glue on the exit slide and nippers.	Remove the glue.
The book buckles when cover is applied.	The book is too thin for the cover weight.	Select a lighter cover
The cover does not show a sharp crease on the spine.	The card is heavy and the covers varnished. Cover cross grained.	Crease the covers.

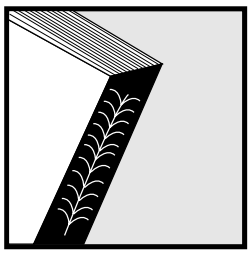
5. SOME COMMON GLUEING DEFECTS

Gaps in glue film



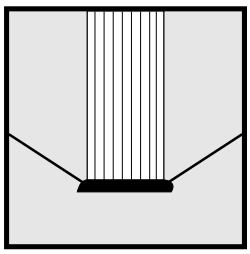
Check:
- Glue and roller temperature.
- Running temperature.
- Adhesive level in tank.

Feather on book spine



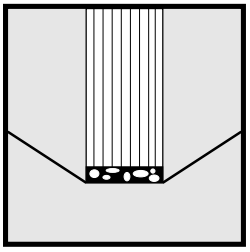
Adhesive and/or roller temperature too low.

Nail head



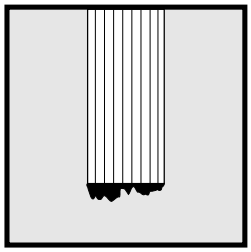
Check:
- Cover press too tight.
- Height of back pressure.

Honeycomb film



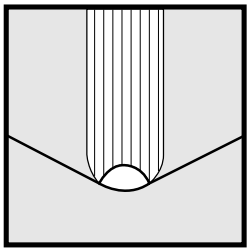
Check:
- Glue and roller temperature.
- Level of adhesive in the tank.
- Moisture in the cover or book stock.

Uneven glue line



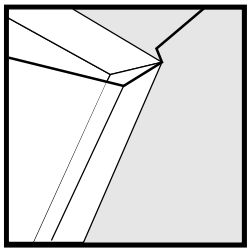
Insufficient adhesive applied.

Cavity spine



Cover press too tight.
Sharpen the knife.

Cover register



Cover feed is not square with the cover clamp.

6. ENVIRONMENTAL COMPLIANCE

Product Recycling and Disposal

ENGLISH:

Application of this symbol on your equipment is confirmation that you must dispose of this equipment in compliance with agreed national Procedures.
In accordance with European legislation dealing with "end of life electrical and electronic equipment", equipment subject to disposal must be managed within agreed procedures.
Prior to disposal please contact your local representative for end of life take back information.

FRANÇAIS:

La présence de ce symbole sur cet équipement indique que ce dernier doit être mis au rebut selon les conventions nationales.
Conformément à la législation européenne, tout équipement électrique et électronique en fin de vie et destiné au rebut doit être manipulé selon les procédures convenues.
Veuillez contacter votre distributeur pour en savoir plus sur la reprise du matériel avant toute mise au rebut.

ESPAÑOL:

La aplicación de este símbolo en el equipo es una confirmación de que en el momento de deshacerse de este equipo debe de hacerlo de acuerdo con los procedimientos nacionales acordados.
La legislación europea exige que para deshacerse de equipos eléctricos y electrónicos al final de su duración útil deben seguirse los procedimientos acordados.
Antes de deshacerse de un equipo póngase en contacto con su distribuidor local o con el representante para obtener información sobre su devolución.

DEUTSCH:

Geräte die dieses Symbol tragen, müssen den nationalen Richtlinien gemäß entsorgt werden.
Den europäischen Bestimmungen zum Umgang mit elektrischen und elektronischen Altgeräten ist Folge zu leisten.
Bei der Entsorgung des Geräts den Partner kontak-tieren.

ITALIANO:

Questo simbolo applicato sulla macchina indica la necessità di smaltire il prodotto in conformità con le normative nazionali vigenti.
La legislazione europea richiede che lo smaltimento dei dispositivi elettrici ed elettronici a fine vita venga gestito in conformità con le normative vigenti.
Prima di smaltire il dispositivo, rivolgersi al rivenditore autorizzato di zona per informazioni sul ritiro dei prodotti a fine vita.

NEDERLANDS:

De aanwezigheid van dit symbool op uw apparatuur geeft aan dat u zich van deze apparatuur moet ontdoen overeenkomstig de daarvoor in het betreffende land geldende procedures.
Krachtens de Europese wetgeving moet de verwerking van afval van gebruikte elektrische en elektronische apparatuur geschieden overeenkomstig de daarvoor geldende procedures.
Neem voordat u de apparatuur wegdoet contact op met uw plaatselijke dealer of vertegenwoordiger voor informatie over inzameling.

National Coolbind 1300

National Starch & Chemical B.V.

Postbus 13
7200 AA Zutphen
Nederland
Tel. 05750-106 66
Fax 05750-111 85

0199/MB/01

COOL-BIND 1300
134-1300

Description	**Appearance**
Formulated hot melt adhesive.	Yellow solid.

Technical Characteristics	**Typical Data**
Viscosity (Brookfield Thermosel Sp 27, 20 rpm)	11,000 mPa.s. @ 130°C 7,800 mPa.s. @ 140°C 4,600 mPa.s. @ 150°C
Softening Point	90°C

Typical Applications

* Unsewn binding.
* Spine gluing where a low application temperature is required

Typical Properties

Tack : Medium

Open Time : Medium

Trim Time : Medium

Features	Benefits
* Low application temperature gives many benefits.	* Reduced degradation results in less problems from char build and reduced maintenance
	* Low application temperature means no "warm-up" period and no need for a set-back temperature
	* Good page pull strengths on a wide variety of papers.

Application Guide

COOL-BIND 1300 can be applied using any conventional bookbinding machine i.e. roller in pot. Apply at temperatures over 130°C and below 150°C. The back spinner should be 20°C to 30°C hotter than the pot temperature.

Packaging

Consult local sales office.

Storage & Handling

Rotate stock using oldest material first.
Keep containers upright and closed to prevent contamination.
Do not mix with other adhesives.
Store under ambient conditions preferably below 30°C and above 10°C to avoid water condensation.
Shelf life : Minimum 1 year under recommended conditions.

HEALTH & SAFETY.

Users should familiarise themselves with the safety data sheet before using or handling this product.

National Starch & Chemical B.V.

February 2, 1999

*** SAFETY DATA SHEET ***

1. CHEMICAL PRODUCT AND COMPANY IDENTIFICATION

PRODUCT NAME..... COOL-BIND 1300

National Starch & Chemical B.V.
Hoornwerk 45
7201 GS Zutphen
Netherlands
EMERGENCY TELEPHONE:
+31 (0) 575 582500 (Business hours)

2. COMPOSITION/INFORMATION ON INGREDIENTS

CHEMICAL FAMILY..... Hot Melt Adhesive

No components which pose a risk.

3. HAZARDS IDENTIFICATION

No European Danger category (67/548/EEC and amendments).

EYE.....	As supplied: no hazard. As used: severe thermal hazard.
SKIN CONTACT.....	As supplied: no hazard. As used: severe thermal hazard.
INHALATION.....	Vapours and/or aerosols which may be formed at elevated temperatures may be irritating to eyes and respiratory tract.
INGESTION.....	Low order of toxicity.

4. FIRST-AID MEASURES

EYE	If hot: flush with cool water. Treat as wax or resin burn. Do not attempt to remove solidified adhesive. Get medical attention immediately. As supplied: remove as foreign body.
SKIN CONTACT	If hot: flush with cool water. Treat as wax or resin burn. Do not attempt to remove solidified adhesive. Get medical attention immediately. As supplied: Non-hazardous.
INHALATION	Remove to fresh air. Get medical attention if irritation persists.
INGESTION	None required.

5. FIREFIGHTING MEASURES

AUTOFLAMMABILITY	Not Applicable
FLASH POINT	>250 C
EXTINGUISHING MEDIA	CO2; Dry chemical
SPECIAL FIREFIGHTING PROCEDURES	No special procedures are required
FIRE & EXPLOSION HAZARDS	Not applicable.
HAZARDOUS COMBUSTION PRODUCTS	Carbon monoxide, carbon dioxide, unknown hydrocarbons.
UPPER EXPLOSION LIMIT (%)	Not Applicable
LOWER EXPLOSION LIMIT (%)	Not Applicable

6. ACCIDENTAL RELEASE MEASURES

SPILL AND LEAK PROCEDURES	Allow to cool and solidify. Scrape up and collect in suitable containers for disposal.

For safety and environmental precautions, please review entire Safety Data Sheet for necessary information.

7. HANDLING AND STORAGE

STORAGE TEMPERATURE	Ambient.
SPECIAL SENSITIVITY	No special sensitivity.
HANDLING/STORAGE	Store in a cool, dry area. Precaution: this product should only be heated to recommended temperatures. The hazards of pyrolysis products are unknown.
VENTILATION REQUIREMENTS	Local exhaust over glue chamber.
SENSITIVE TO STATIC ELECTRICITY?	No

8. EXPOSURE CONTROLS/PERSONAL PROTECTION

VENTILATION REQUIREMENTS	Local exhaust over glue chamber.
EYE PROTECTION REQUIREMENTS	Safety glasses, goggles or face shield to protect against splashing.
GLOVE REQUIREMENTS	Thermally resistant gloves should be worn.
CLOTHING REQUIREMENTS	Uniforms, coveralls, or a lab coat should be worn.
RESPIRATORY REQUIREMENTS	None required if good ventilation is maintained.

9. PHYSICAL AND CHEMICAL PROPERTIES

PURE SUBSTANCE OR PREPARATION	Preparation
PHYSICAL FORM	Solid
APPEARANCE/ODOUR	Amber; No odour
ODOUR THRESHOLD	Not available.
pH AS IS	Not Applicable
BOILING POINT	>250 C
MELTING/FREEZING POINT	90 - 100 C
SOLUBILITY IN WATER	Insoluble
PARTITION COEFFICIENT (n-octanol/water)	Not Applicable
RELATIVE DENSITY	1.000
EVAPORATION RATE	Not Applicable
VAPOUR PRESSURE (mmHg)	Not Applicable
VAPOUR DENSITY (air=1)	Not Applicable
VOLATILES	None.
VOLATILE ORGANIC COMPOUNDS	<1 g/l (180 C)
AUTOFLAMMABILITY	Not Applicable
FLASH POINT	>250 C
OXIDIZING PROPERTIES	Not Applicable

10. STABILITY AND REACTIVITY

STABILITY	Stable
HAZARDOUS DECOMPOSITION PRODUCTS	Not applicable.

11. TOXICOLOGICAL INFORMATION

PRODUCT TOXICOLOGY

PRODUCT INFORMATION	Not established.

CHRONIC (LONG TERM) EFFECTS OF EXPOSURE

ROUTE OF ENTRY	Inhalation; Skin contact; Eye contact
EFFECTS OF CHRONIC EXPOSURE	Although this product has not been tested for chronic effects it is judged as having a low order of toxicity based on component information. Use of good industrial hygiene practices is recommended.
TARGET ORGANS	None known.
SPECIAL HEALTH EFFECTS	None known.

12. ECOLOGICAL INFORMATION

POTENTIAL EFFECT ON ENVIRONMENT....	Unknown.
MOBILITY.....	Unknown.
PERSISTENCE AND DEGRADABILITY.....	Unknown
POTENTIAL TO BIOACCUMULATE.....	No
ECOTOXICITY.....	Unknown.
AQUATIC TOXICITY.....	None established.

13. DISPOSAL CONSIDERATIONS

WASTE DISPOSAL METHODS.....	Waste disposal should be in accordance with existing Community,National and local regulations.
EMPTY CONTAINER WARNINGS.....	Not needed.

14. TRANSPORT INFORMATION (See also section 9)

ADR/RID.....	Not Applicable
CEFIC TREMCARD NUMBER.....	Not Applicable
HAZCHEM CODE.....	Not Applicable
KEMMLER CODE.....	Not Applicable
IMDG CLASSIFICATION.....	Not Applicable
IATA CLASSIFICATION.....	Not Applicable
U.N. NUMBER (S.I.N.).....	Not Applicable
U.N. CLASS, PACKING GROUP.....	Not Applicable

15. REGULATORY INFORMATION

EEC HAZARD CLASSIFICATION..... None.

Directives 88/379/EEC and 91/155/EEC have been considered when compiling this SDS; the information is provided for health and safety assessment by an industrial user. Reference should be made to any relevent local or national health, safety, and environmental legislation. This information does not constitute indication of suitability for specific uses.

16. OTHER INFORMATION

MSDS DATE..... 18 January 1999

FOR REGULATORY INFORMATION, CONTACT:

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Divisional Product Assurance Manager
Adhesives - Europe
National Starch & Chemical Ltd
Galvin Road
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United Kingdom
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Fax: +32 (0) 10 / 61 69 03
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